

**HiFill® PA6/6 LG/LCF40 IM 2008**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber/Carbon Fiber, 40% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.40		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	3.10E+6	psi	ASTM D638
Tensile Strength (Yield)	38000	psi	ASTM D638
Tensile Strength (Break)	37500	psi	ASTM D638
Tensile Elongation (Break)	1.0 to 2.0	%	ASTM D638
Flexural Modulus	2.40E+6	psi	ASTM D790
Flexural Strength	54000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	8.0	ft·lb/in	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	475	°F	ASTM D648
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	1.0E+8	ohms	ASTM D257
Volume Resistivity	1.0E+8	ohms·cm	ASTM C611

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	535 to 555	°F
Middle Temperature	540 to 560	°F
Front Temperature	550 to 570	°F
Nozzle Temperature	545 to 565	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

