

HiFill® PA6/6 LGF50 HS L BK 12mm

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.59		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.10E+6	psi	ASTM D638
Tensile Strength (Yield)	26500	psi	ASTM D638
Tensile Strength (Break)	26000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.8	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 560	°F
Processing (Melt) Temp	500 to 560	°F
Mold Temperature	150 to 250	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

¹ Typical properties: these are not to be construed as specifications.

