

HiFill® PA6/6 ML2 HS BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Features	• Wear Resistant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value Unit	Test Method
Density / Specific Gravity	1.15	ASTM D792
Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	500000 psi	ASTM D638
Tensile Strength (Yield)	11000 psi	ASTM D638
Tensile Elongation (Break)	23 %	ASTM D638
Impact	Nominal Value Unit	Test Method
Notched Izod Impact (0.125 in)	0.90 ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value Unit
Drying Temperature	180 °F
Drying Time	4.0 hr
Rear Temperature	520 to 540 °F
Middle Temperature	520 to 550 °F
Front Temperature	530 to 550 °F
Nozzle Temperature	520 to 540 °F
Processing (Melt) Temp	535 to 570 °F
Mold Temperature	150 to 180 °F
Injection Rate	Slow
Back Pressure	0.00 to 100 psi
Screw Speed	Slow-Moderate

Notes

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

