

HiFill® PA6/6 LGF60 2000 12mm

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Long Glass Fiber
Features	• Heat Stabilized • Lubricated
Appearance	• Black • Colors Available
Forms	• Pellets ¹
Processing Method	• Injection Molding

Properties ²

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.69		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3 to 3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	41000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	3.00E+6	psi	ASTM D790
Flexural Strength	59000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	9.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648
CLTE - Flow	1.5E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Slow
 Recommendations for Molding and Tool Conditions: Well vented
 Moisture Content, as received: Product is packaged at 0.2% or less.
 Recommended Max Moisture: 0.12% down to 0.08%

