

HiFill® PA6/12 CF30 BK

Techmer Polymer Modifiers - *Polyamide 612*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Appearance	• Black • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.16	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	29000	psi	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	2.30E+6	psi	ASTM D790
Flexural Strength	44000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	2.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	430	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	420	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Additional Information	Nominal Value	Unit	Test Method
TPCI #	9814104		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	165 to 220	°F
Drying Time	2.0 to 16	hr
Rear Temperature	520 to 540	°F
Middle Temperature	530 to 550	°F
Front Temperature	510 to 530	°F
Nozzle Temperature	500 to 520	°F
Processing (Melt) Temp	520 to 540	°F
Mold Temperature	130 to 180	°F

Notes

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

