

HiFill FR® J-4 30 V0 NATL

 Techmer Polymer Modifiers - *Polyamide 612*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber
Additive	<ul style="list-style-type: none"> Flame Retardant
Features	<ul style="list-style-type: none"> Flame Retardant
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.57		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.53E+6	psi	ASTM D638
Tensile Strength (Yield)	21000	psi	ASTM D638
Tensile Strength (Break)	19500	psi	ASTM D638
Tensile Elongation (Break)	1.9	%	ASTM D638
Flexural Modulus	1.43E+6	psi	ASTM D790
Flexural Strength	33000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.8	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	387	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.030 in		V-0	
0.06 in		V-0	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	525 to 560	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 175	°F
Injection Rate		Slow
Back Pressure	25.0 to 75.0	psi
Screw Speed		Slow-Moderate

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