

HiFill® PA6/12 14082 GB30 BK

Techmer Polymer Modifiers - *Polyamide 612*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		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	460000	psi	ASTM D638
Tensile Strength (Yield)	5800	psi	ASTM D638
Tensile Strength (Break)	5500	psi	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.50	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	500 to 530	°F
Middle Temperature	510 to 540	°F
Front Temperature	520 to 550	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	125 to 180	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

Notes

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

