

**HiFill® PA6/12 GF30 LE RD158**

 Techmer Polymer Modifiers - *Polyamide 612*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Filler / Reinforcement	<ul style="list-style-type: none"> <li>Glass Fiber, 30% Filler by Weight</li> </ul>
Agency Ratings	<ul style="list-style-type: none"> <li>FDA</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Red</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.32		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 0.010	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.33E+6	psi	ASTM D638
Tensile Strength (Yield)	22500	psi	ASTM D638
Tensile Strength (Break)	22500	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.8	ft·lb/in	ASTM D256

**Processing Information**

	<b>Nominal Value</b>	<b>Unit</b>
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	480 to 520	°F
Middle Temperature	490 to 530	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	510 to 550	°F
Processing (Melt) Temp	490 to 550	°F
Mold Temperature	125 to 200	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 50.0	psi
Screw Speed	Slow-Moderate	

**Notes**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

