

HiFill® PA6/10 AF33 IM BK

 Techmer Polymer Modifiers - *Polyamide 610*
General Information
General

| | |
|------------------------|--------------------------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Aramid Fiber, 33% Filler by Weight |
| Additive | • Impact Modifier |
| Features | • Impact Modified |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.14 | | ASTM D792 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 500000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 15000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 15 | % | ASTM D638 |
| Flexural Modulus | 500000 | psi | ASTM D790 |
| Flexural Strength | 17000 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 3.6 | ft·lb/in | ASTM D256 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|----------------------|-------------|
| Drying Temperature | 180 | °F |
| Drying Time | 2.0 to 3.0 | hr |
| Rear Temperature | 460 to 490 | °F |
| Middle Temperature | 470 to 500 | °F |
| Front Temperature | 480 to 510 | °F |
| Nozzle Temperature | 490 to 520 | °F |
| Processing (Melt) Temp | 470 to 520 | °F |
| Mold Temperature | 75 to 150 | °F |
| Injection Rate | Slow | |
| Back Pressure | 0.00 to 50.0 | psi |
| Screw Speed | Slow-Moderate | |

Notes

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

