

HiFill® 6-900001 BLACK UV GF15

Techmer Polymer Modifiers - *Polyamide 12*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11400	psi	ASTM D638
Tensile Elongation (Break)	5600	%	ASTM D638
Flexural Modulus	470000	psi	ASTM D790
Flexural Strength	17200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.7	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 525	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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

