

## HiFill FR® PA4/6 GF10 FR HS L GN611660

Techmer Polymer Modifiers - *Polyamide 46*

### General Information

| General                |                                     |                   |
|------------------------|-------------------------------------|-------------------|
| Material Status        | • Commercial: Active                |                   |
| Availability           | • North America                     |                   |
| Filler / Reinforcement | • Glass Fiber, 10% Filler by Weight |                   |
| Additive               | • Flame Retardant                   | • Heat Stabilizer |
| Features               | • Flame Retardant                   | • Heat Stabilized |
| Appearance             | • Green                             |                   |
| Processing Method      | • Injection Molding                 |                   |

### Properties <sup>1</sup>

| Physical                            | Nominal Value    | Unit     | Test Method |
|-------------------------------------|------------------|----------|-------------|
| Density / Specific Gravity          | 1.52             |          | ASTM D792   |
| Molding Shrinkage - Flow (0.125 in) | 5.0E-3 to 7.0E-3 | in/in    | ASTM D955   |
| Mechanical                          | Nominal Value    | Unit     | Test Method |
| Tensile Modulus                     | 750000           | psi      | ASTM D638   |
| Tensile Strength (Yield)            | 9000             | psi      | ASTM D638   |
| Tensile Strength (Break)            | 8500             | psi      | ASTM D638   |
| Tensile Elongation (Break)          | 1.5              | %        | ASTM D638   |
| Impact                              | Nominal Value    | Unit     | Test Method |
| Notched Izod Impact (0.125 in)      | 0.60             | ft·lb/in | ASTM D256   |
| Flammability                        | Nominal Value    | Unit     | Test Method |
| Flame Rating                        |                  |          | UL 94       |
| 0.06 in                             | V-0              |          |             |
| 0.12 in                             | V-0              |          |             |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 200           | °F   |
| Drying Time            | 2.0 to 3.0    | hr   |
| Rear Temperature       | 570 to 600    | °F   |
| Middle Temperature     | 580 to 610    | °F   |
| Front Temperature      | 590 to 620    | °F   |
| Nozzle Temperature     | 595 to 625    | °F   |
| Processing (Melt) Temp | 570 to 625    | °F   |
| Mold Temperature       | 150 to 250    | °F   |
| Injection Rate         | Slow          |      |
| Back Pressure          | 0.00 to 50.0  | psi  |
| Screw Speed            | Slow-Moderate |      |

