

HiFill® PA12 GF30 HS L BK

Techmer Polymer Modifiers - *Polyamide 12*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Conductive • Heat Stabilized • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	950000	psi	ASTM D638
Tensile Strength (Yield)	15200	psi	ASTM D638
Tensile Strength (Break)	15000	psi	ASTM D638
Tensile Elongation (Break)	3.8	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	165	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	410 to 460	°F
Middle Temperature	420 to 470	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	450 to 500	°F
Processing (Melt) Temp	420 to 490	°F
Mold Temperature	150 to 225	°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.

