HiFill® PA6/6,6 GF33 IM HS L

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight	
Additive	• Heat Stabilizer	• Impact Modifier
Features	• Heat Stabilized	• Impact Modified
Appearance	• Natural Color	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.30E+6	psi	ASTM D638
Tensile Strength (Yield)	19000	psi	ASTM D638
Tensile Strength (Break)	18500	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	3.5	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	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	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

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