

HiFill® PA6/6,6 IM L

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier • Lubricant
Features	• Impact Modified • Lubricated
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.09		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7400	psi	ASTM D638
Tensile Elongation (Break)	65	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	15	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

