

HiFill® PA6/ABS 1120 A4

Techmer Polymer Modifiers - *Polyamide 6 + ABS*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.05		ASTM D792
Molding Shrinkage	0.80	%	ISO 294-4
Water Absorption (24 hr)	1.2	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	250000	psi	ASTM D638
Tensile Strength (Yield)	5500	psi	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638
Flexural Modulus	260000	psi	ASTM D790
Flexural Strength	8900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	16	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	185	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	149	°F	ASTM D648
CLTE - Flow	5.5E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+12 to 1.0E+16	ohms·cm	ASTM C611

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	465 to 520	°F
Middle Temperature	465 to 520	°F
Front Temperature	465 to 520	°F
Nozzle Temperature	465 to 520	°F
Processing (Melt) Temp	465 to 525	°F
Mold Temperature	105 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

Notes

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

