

HiFill® J-71/20

 Techmer Polymer Modifiers - *Polyamide + SAN*
General Information
General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.24		ASTM D792
Molding Shrinkage - Flow	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.070	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	16000	psi	ASTM D638
Tensile Elongation (Yield)	2.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength (Yield)	20000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.250 in)	1.8	ft-lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	380	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	220	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.080	%
Rear Temperature	520	°F
Middle Temperature	540	°F
Front Temperature	530	°F
Nozzle Temperature	520	°F
Processing (Melt) Temp	540	°F
Mold Temperature	165	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi

