

HiFill® PA FW24 BLUE 4306

 Techmer Polymer Modifiers - *Polyamide*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Blue
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.70		ASTM D792
Moisture (311°F)	0.11	%	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2.49E+6	psi	ISO 178
Flexural Stress	47000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact Strength	27	ft·lb/in ²	ISO 180

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	

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