

**HiFill® PA4/6 GF30 FR HS L**

 Techmer Polymer Modifiers - *Polyamide 46*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Flame Retardant • Heat Stabilized • Lubricated
UL File Number	• E157318
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.68		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Break)	16000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	720000	psi	ASTM D790
Flexural Strength	24000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	2.5	ft·lb/in	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	550	°F	ASTM D648
CLTE - Flow	2.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Volume Resistivity	1.0E+11	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	600	V/mil	ASTM D149
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-0		UL 94

**Processing Information**

	<b>Nominal Value</b>	<b>Unit</b>
<b>Injection</b>		
Drying Temperature	185	°F
Drying Time	4.0 to 8.0	hr
Rear Temperature	540 to 600	°F
Middle Temperature	540 to 600	°F
Front Temperature	540 to 600	°F
Processing (Melt) Temp	475 to 600	°F
Mold Temperature	190 to 260	°F
Back Pressure	0.00 to 50.0	psi
Screw Speed	40 to 80	rpm

