HiFill® PA4/6 GF5 IM HS BK

Techmer Polymer Modifiers - *Polyamide 46*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber, 5.0% Filler by Weight	
Additive	• Heat Stabilizer	• Impact Modifier
Features	• Heat Stabilized	• High Impact Resistance
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010	in/in	ASTM D955
Water Absorption (24 hr)	2.6	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	9.5	%	ASTM D638
Flexural Modulus	420000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.5	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	320	°F	ASTM D648
CLTE - Flow	3.2E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+11	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	700	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
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