

HiFill® PA6 IM 409 L MB

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 IM 409 L MB is a Polyamide 6 (Nylon 6) product. It can be processed by injection molding and is available in North America.

Characteristics include:

- Flame Rated
- Heat Stabilizer
- Impact Modified
- Impact Resistant
- Lubricated

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
	Lubricant		
Features	Heat Stabilized		
	High Impact Resistance		
	Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.6	%	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	66.9	MPa	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	79.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	130	J/m	
23°C, 3.18 mm	160	J/m	
Unnotched Izod Impact (3.18 mm)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Unannealed	154	°C	
1.8 MPa, Unannealed	60.0	°C	
CLTE - Flow	8.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+13	ohms·cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	254 to 291	°C	
Middle Temperature	254 to 291	°C	
Front Temperature	254 to 291	°C	
Processing (Melt) Temp	238 to 277	°C	
Mold Temperature	65.6 to 82.2	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
NOTE			

1. Method A (Short-Time)

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