

HiFill® PA6 IM 811 HS L

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 IM 811 HS L 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	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.07	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.80	--	%	ASTM D955
Water Absorption (24 hr)	1.5	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	125	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Yield)	48.3	41.4	MPa	ASTM D638
Tensile Elongation (Break)	230	300	%	ASTM D638
Flexural Modulus	1210	862	MPa	ASTM D790
Flexural Strength	58.6	51.7	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	No Break	No Break		ASTM D256
Unnotched Izod Impact (3.18 mm)	No Break	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method

Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed	166	--	°C	
1.8 MPa, Unannealed	51.7	--	°C	
CLTE - Flow	2.3E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	2.0E+13	--	ohms·cm	ASTM D257
Dielectric Strength ¹	17	--	kV/mm	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating	HB	--		UL 94
Additional Information	Dry	Conditioned		
TPCI #	6109102	--		
Injection	Dry	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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