

HiFill® XRD PA66 0134 LE

Polyamide 66
Techmer Engineered Solutions

Message:
Nylon PA66, Metallic Filler, Activated for Metal and X-Ray Detection, Low Extractables for FDA Compliant Applications

General Information			
Features	Low Extractables		
	Metal Detectable		
Agency Ratings	FDA Unspecified Rating		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	2.0	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	72.4	MPa	ASTM D638
Tensile Elongation (Yield)	10	%	ASTM D638
Flexural Modulus	2830	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	37	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	138	°C	
1.8 MPa, Unannealed	82.2	°C	
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	282 to 293	°C	
Middle Temperature	288 to 299	°C	
Front Temperature	277 to 288	°C	
Nozzle Temperature	282 to 293	°C	
Processing (Melt) Temp	282 to 304	°C	

Mold Temperature	54.4 to 93.3	°C
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