

HiFill® XRD POM 0161 LE YL149

Polyamide 66
Techmer Engineered Solutions

Message:
Acetal Copolymer , Proprietary Filler for 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	1.62	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	2.1	%	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1650	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	42.7	MPa	
Break	40.0	MPa	
Tensile Elongation (Yield)	25	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	83	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	160	°C	
1.8 MPa, Unannealed	110	°C	
CLTE - Flow	2.2E-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	71.1	°C	
Drying Time	1.0	hr	

Rear Temperature	177 to 193	°C
Middle Temperature	188 to 210	°C
Front Temperature	182 to 199	°C
Nozzle Temperature	177 to 204	°C
Processing (Melt) Temp	193 to 216	°C
Mold Temperature	82.2 to 121	°C

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