

**HiFill® XRD PA66 0134 LE**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
**Product Description**

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

**General**

Material Status	• Commercial: Active
Availability	• North America
Features	• Low Extractables • Metal Detectable
Agency Ratings	• FDA
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Elongation (Yield)	10	%	ASTM D638
Flexural Modulus	410000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.70	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	280	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	180	°F	ASTM D648
CLTE - Flow	2.2E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
