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TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH A2E 219 V35 BK H

(Previously ECONAMID FL 66G35H1 BK)

Polyamide 66, 35% glass fiber reinforced, organic heat stabilized, for injection moulding, black

General

Feature	Organic heat stabilized
Polymer type	PA66 (Polyamide 66)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA66-GF35
ISO 16396 designation	PA66,GF35(R100),M1H,S14-100

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.41
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	0.6 - 0.8
Viscosity number	96% H2SO4	ISO 307	cm³/g	135
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9900 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	150 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8600 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	230 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	45 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	6.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	38 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	6 / -

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	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	250
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	245
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	250
Electrical properties				
Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+013
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products.
**: conditioned according to ISO 1110*

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	270 - 290 °C
Recommended mould temperature	90 - 110 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. Thess TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

Disclaimer