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TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH A3E 216M BK

General

Feature	Impact modified	
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Automotive Applications	
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-I
ISO 16396 designation	PA66-I,(R>50),M1,S14-030

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.11
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.4 - 1.6
Molding shrinkage, normal		ISO 294-4, 2577	%	1.5 - 1.7
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm³/10 min	85 - 105
Melt flow rate, MFR		ISO 1133	g/10 min	100
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2100 / 750
Stress at break		ISO 527-1/-2	MPa	50 / 30
Strain at break		ISO 527-1/-2	%	9 / 45
Yield stress		ISO 527-1/-2	MPa	- / 35
Yield strain		ISO 527-1/-2	%	5 / 35
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	1800 / 650
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	75 / 45
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	30 / 100
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	3 / 6

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	Condition	Standard	Unit	Value

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	261
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	189
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	70

Burning behaviour

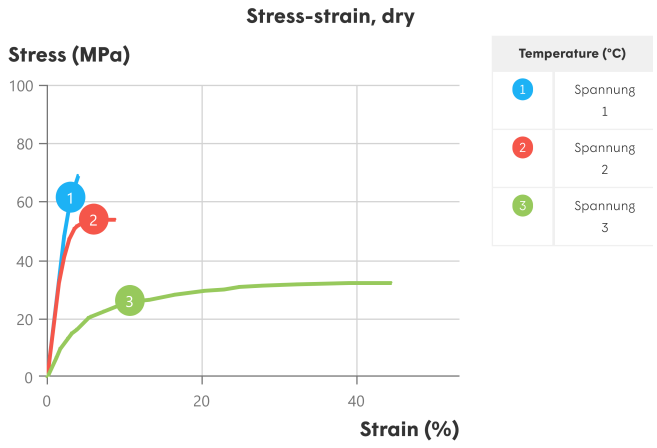
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		<100

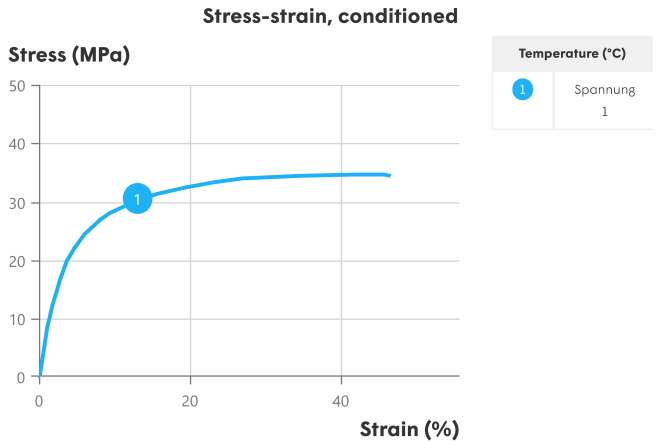
Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products.
**: conditioned according to ISO 1110*

Processing conditions

Drying temperature/time	80
Suggested max moisture	0.2 %
Rear temperature	270 - 280 °C
Middle temperature	275 - 285 °C
Front temperature	280 - 290 °C
Recommended mould temperature	70 - 100 °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.





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