

TECHNICAL DATA SHEET

TECHNYL A 216T V33 BK 1N

TECHNYL A 216T V33 BK 1N is a polyamide PA66 reinforced with 33% of glass fibre, heat stabilized, for injection moulding. This grade offers an excellent combination between thermal and mechanical properties.

General

Feature	IR-laser markable	Organic heat stabilized
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Automotive Applications	Electrical/Electronic Applications
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-G33
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	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.4
Water absorption	24 hr, 23°C	ISO 62	%	0.78
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	1.1

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	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	11000 / 8300
Stress at break		ISO 527-1/-2	MPa	200 / 145
Strain at break		ISO 527-1/-2	%	2.8 / 4.3
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9200 / 6400
Flexural modulus, ASTM D790	2 mm/min	ASTM D790	MPa	10600 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	190 / -
Flexural strength, ASTM D790	2 mm/min	ASTM D790	MPa	270 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	70 / 78
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	13 / 17
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	65 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	12 / 17

Thermal properties

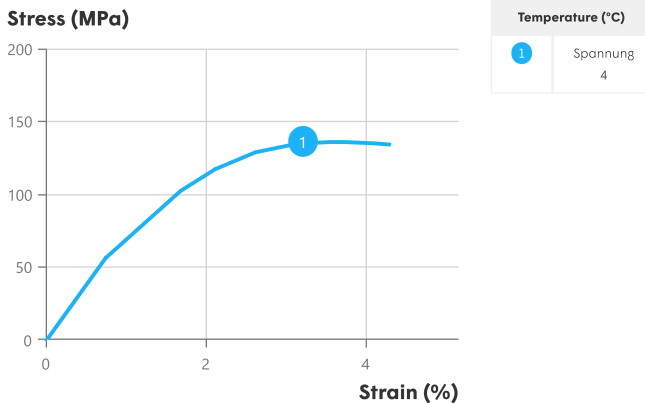
Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	255

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	80 °C
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

Stress-strain, conditioned



Injection notes

The material is supplied in airtight bags, ready for use. In case that the virgin material has absorbed moisture, it must be dried with a dehumidified air drying equipment, dew point minimum -20°C. Recommended time 2-4h.

Injection advice

For reinforced polyamides, Domo recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 / 1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 / 1.2379 (DIN Norm). In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design.

Disclaimer

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