

## TECHNICAL DATA SHEET

### TECHNYL A 246 NC

(Previously DOMAMID 6614 NC)

Polyamide 66, impact modified, for injection moulding

#### General

Feature	Impact modified
Polymer type	PA66 (Polyamide 66)
Processing technology	Injection molding
Certification	RoHS

#### Product identification

ISO 1043 abbreviation	PA66-I
ISO 16396 designation	PA66-I,M1,S14-020

Condition	Standard	Unit	Value
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#### Physical properties

Density		ISO 1183	g/cm <sup>3</sup>	1.08
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.4 - 1.6
Molding shrinkage, normal		ISO 294-4, 2577	%	1.6 - 1.8

#### Mechanical properties

dam / cond.\*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1900 / 900
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / 50
Yield stress	50 mm/min	ISO 527-1/-2	MPa	50 / 40
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	1800 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	70 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU		NB / NB
Charpy impact strength, -30°C	-30°C	ISO 179/1eU		NB / NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	65 / 105
Izod impact strength, +23°C	+23°C	ISO 180/1U		NB / NB
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	65 / 95
Rockwell hardness		ISO 2039/2	ScaleR	110 / -

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	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	165
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	65
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	220

## Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+016
Surface resistivity		IEC 62631-3-1	ohm	1E+014
Comparative tracking index	Solution A	IEC 60112	V	600
CTI performance level category		Sol A		PLC 0

## 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 natural colored 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	40 - 80 °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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