

TECHNICAL DATA SHEET

TECHNYL AR 218 V30 BK

TECHNYL AR 218 V30 BK is a polyamide 66, reinforced with 30% of glass fiber, heat stabilized, for injection moulding. It contains recycled materials. This grade offers a good combination between thermal and mechanical properties.

General

Feature	Heat-aging stabilized		
Polymer type	PA66 (Polyamide 66)		
Processing technology	Injection molding		
Certification	RoHS	EC 1907/2006 (REACH)	
Applications	General Purpose		
Colors available	Black		
Forms	Pellets		

Product identification

ISO 1043 abbreviation	PA66-GF30
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	Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.37
Water absorption	24 hr, 23°C	ISO 62	%	0.8
Water absorption, saturation			%	5.3

Mechanical properties

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Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9900 / 6300
Stress at break		ISO 527-1/-2	MPa	150 / 90
Strain at break		ISO 527-1/-2	%	2.4 / 4
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7000 / 5000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	200 / 135
Flexural strength, ASTM D790	2 mm/min	ASTM D790	MPa	220 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	45 / 55
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	8 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	6 / 11
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	8 / -

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Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	260
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	240
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	235

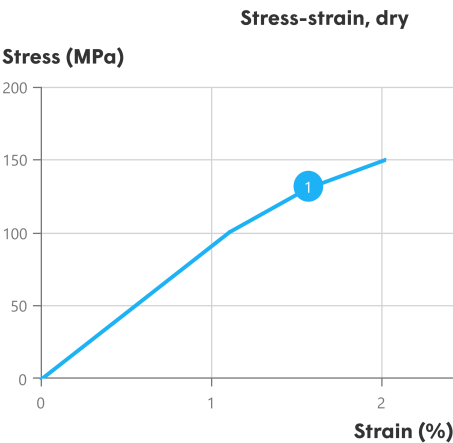
Burning behaviour

Flammability, 1.5 mm	1.5 mm	UL 94		HB
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	650
Oxygen index			%	23

*: conditioned according to ISO 1110

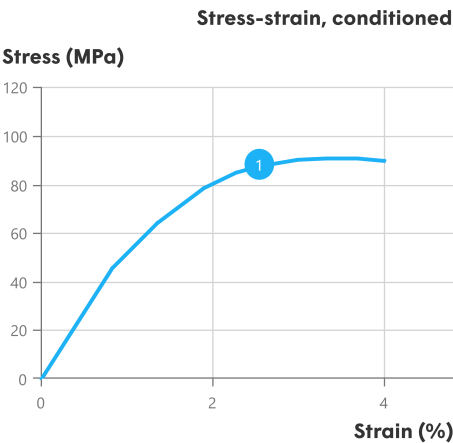
Processing conditions

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



Temperature (°C)

1 Spannung 1



Temperature (°C)

1 Spannung 4

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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