

TECHNICAL DATA SHEET

TECHNYL RED A 218HPS V35 BK 21N

TECHNYL RED A 218HPS V35 BK 21N is a polyamide blend of polyamide 6.6 polyamide 6 reinforced with 35% of glass fiber, high heat stabilized for injection moulding. This grade is designed to offer a long term heat resistance and is suitable to work in environments characterized by a very high temperature. (210°C)

General

Feature	Heat-aging stabilized Excellent surface finish	Very high flow heat resistant
Polymer type	(PA66 + PA6) blend	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Automotive Applications	
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66+PA6-GF35
-----------------------	---------------

Condition	Standard	Unit	Value
-----------	----------	------	-------

Physical properties

Density		ISO 1183	g/cm <sup>3</sup>	1.42
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	0.65 - 0.75

TECHNICAL DATA SHEET

TECHNYL RED A 218HPS V35 BK 21N

	Condition	Standard	Unit	Value
Mechanical properties			dam / cond.*	
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	11600 / 6500
Stress at break		ISO 527-1/-2	MPa	195 / 115
Strain at break		ISO 527-1/-2	%	3.3 / 6.6
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9800 / 5900
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	300 / 190
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	90 / 95
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m²	78 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	13 / 22
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	9 / -

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	250
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	248
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	226

\*: 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

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

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.