

TECHNICAL DATA SHEET

TECHNYL SAFE A 302FC NC
(Previously TECHNYL A 302 NATURAL FA)

TECHNYL SAFE A 302FC NC is a polyamide PA66, unfilled, medium viscosity, food contact approved for extrusion and injection moulding. Designed to offer high impact resistance, good rigidity and excellent compression resistance of extruded and moulded parts requiring food contact compliance in industrial consumer good as well as appliances applications.

General

Feature	Food contact approved Impact resistant	Medium viscosity High melt strength
Polymer type	PA66 (Polyamide 66)	
Processing technology	Extrusion	Injection molding
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Consumer good application Industrial Applications PC / laptop / tablet	home & office furniture Power Tool & Garden Equipment
Colors available	Natural	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.14
Water absorption	24 hr, 23°C	ISO 62	%	1.3
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.6
Molding shrinkage, normal		ISO 294-4, 2577	%	1.7

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3100 / 1600
Stress at break		ISO 527-1/-2	MPa	60 / 60
Strain at break		ISO 527-1/-2	%	55 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3000 / 1400
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	120 / 75
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	6.5 / 25
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	5.5 / 30

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	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	205
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	75

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
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
Dielectric strength	1 mm	IEC 60243-1	kV/mm	22

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	265 - 275 °C
Middle temperature	270 - 280 °C
Front temperature	280 - 285 °C
Recommended mould temperature	60 - 80 °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 unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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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