

TECHNICAL DATA SHEET

TECHNYL STAR AFX 216 V50 GY 2684

TECHNYL STAR AFX 216 V50 GY 2684 is a high flow polyamide 66 resin, reinforced with 50% of glass fibre, for injection moulding. Due to its outstanding flow characteristics, this grade shows exceptional processing behaviour and excellent surface aspect of the finished part.

General

Feature	High dimensional stability Excellent surface finish	Very high flow High stiffness
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Applications	Gears White Goods & Small Appliances	Living Hinges
Colors available	Grey	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-GF50
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.57
Water absorption	24 hr, 23°C	ISO 62	%	0.6
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.25
Molding shrinkage, normal		ISO 294-4, 2577	%	0.5

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	17000 / 12500
Stress at break		ISO 527-1/-2	MPa	255 / 180
Strain at break		ISO 527-1/-2	%	2.5 / 3.5
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	100 / 100
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	15 / 21

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	264
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	256

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	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB

\*: 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 - 290 °C
Recommended mould temperature	60 - 90 °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**

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