

TECHNICAL DATA SHEET

**TECHNYL STAR AFX 216 V50 NC**

TECHNYL STAR AFX 216 V50 NC 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	Natural	Grey
Forms	Pellets	

**Product identification**

ISO 1043 abbreviation	PA66-GF50
-----------------------	-----------

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

**Physical properties**

Density		ISO 1183	g/cm³	1.58
Water absorption	24 hr, 23°C	ISO 62	%	0.7
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	0.65

**Mechanical properties**

dam / cond.\*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	16100 / 12200
Stress at break		ISO 527-1/-2	MPa	258 / 189
Strain at break		ISO 527-1/-2	%	2.9 / 3.1
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	110 / 85
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	16 / 19

**Thermal properties**

Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	256

\*: conditioned according to ISO 1110

TECHNICAL DATA SHEET

TECHNYL STAR AFX 216 V50 NC

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

**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**

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 manufacturers 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.