

TECHNICAL DATA SHEET

TECHNYL STAR AFX 60G1 V45 GY 2633

TECHNYL STAR AFX 60G1 V45 Grey 2633 is a high flow polyamide 66 based on a non-halogenated flame retardant system, reinforced of 45% of glass fiber, heat stabilized, for injection moulding. This grade offers excellent electrical properties combined with flame retardancy performance

General

| | | |
|-----------------------|---|----------------------------------|
| Feature | Halogen and red phosphorus free flame retardant Excellent surface finish | Very high flow High stiffness |
| Polymer type | PA66 (Polyamide 66) | |
| Processing technology | Injection molding | |
| Certification | UL-Yellow Card European Railways Certifications EN 45545-2 | EC 1907/2006 (REACH) |
| Applications | Electrical/Electronic Applications | |
| Colors available | Grey | Blue |
| Forms | Pellets | |

Product identification

| | |
|-----------------------|------------------|
| ISO 1043 abbreviation | PA66-GF45 FR(40) |
|-----------------------|------------------|

| | Condition | Standard | Unit | Value |
|-----------------------------|-------------|-----------------|-------|-------|
| Density | | ISO 1183 | g/cm³ | 1.57 |
| Water absorption | 24 hr, 23°C | ISO 62 | % | 0.6 |
| Molding shrinkage, parallel | | ISO 294-4, 2577 | % | 0.35 |
| Molding shrinkage, normal | | ISO 294-4, 2577 | % | 0.65 |

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| | Condition | Standard | Unit | Value |
|---------------------------------------|-----------|--------------|-------|---------------------|
| Mechanical properties | | | | dam / cond.* |
| Tensile modulus | 1 mm/min | ISO 527-1/-2 | MPa | 15500 / 11400 |
| Stress at break | | ISO 527-1/-2 | MPa | 160 / 115 |
| Strain at break | | ISO 527-1/-2 | % | 1.7 / 2.1 |
| Flexural modulus, ISO 178 | 2 mm/min | ISO 178 | MPa | 13400 / 10900 |
| Flexural strength, ISO 178 | 2 mm/min | ISO 178 | MPa | 290 / 210 |
| Charpy impact strength, +23°C | +23°C | ISO 179/1eU | kJ/m² | 55 / - |
| Charpy notched impact strength, +23°C | +23°C | ISO 179/1eA | kJ/m² | 9.7 / 11 |
| Izod impact strength, +23°C | +23°C | ISO 180/1U | kJ/m² | 53 / 53 |
| Izod notched impact strength, +23°C | +23°C | ISO 180/1A | kJ/m² | 8 / 10 |


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 | 250 |
| Thermal conductivity, through plane | | ASTM E1461 | W/m.K | 0.4 |
| Thermal conductivity, in plane | | ASTM E1461 | W/m.K | 0.4 |

Electrical properties

| | | | | |
|--------------------------------|------------|---------------|-------|--------|
| Volume resistivity | | IEC 62631-3-1 | ohm.m | 1E+013 |
| Surface resistivity | | IEC 62631-3-1 | ohm | 7E+015 |
| 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 | 44 |

Burning behaviour

| | | | | |
|---|--|----------------|----|-----|
| UL Yellow Card availability  | Click here to have access to the UL Yellow Card → QMFZ2.E44716 | | | |
| Flammability, 0.75 mm | 0.75 mm | UL 94 | | V0 |
| Flammability, 1.5 mm | 1.5 mm | UL 94 | | V0 |
| Flammability, 3.0 mm | 3.0 mm | UL 94 | | V0 |
| Glow-wire flammability index, GWFI, 0.75 mm | 0.75 mm | IEC 60695-2-12 | °C | 960 |
| Glow-wire flammability index, GWFI, 1.5 mm | 1.5 mm | IEC 60695-2-12 | °C | 960 |
| Oxygen index | | | % | 34 |

*: conditioned according to ISO 1110

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Processing conditions

| | |
|-------------------------------|--------------|
| Drying temperature/time | 80 °C |
| Suggested max moisture | 0.2 % |
| Rear temperature | 260 - 270 °C |
| Middle temperature | 265 - 275 °C |
| Front temperature | 265 - 280 °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

All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, Domo recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, Domo advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. 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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