

EXPERIMENTAL DATASHEET

TECHNYL 4EARTH A2E 236 BK
(Previously ECONAMID PLUS 66I2 BK)

Polyamide 66, impact modified, for injection moulding, black

General

Feature	Impact modified
Polymer type	PA66 (Polyamide 66)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA66-I
ISO 16396 designation	PA66-I,(R>50),M1,S14-020

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.08
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.8
Water absorption	24 hr, 23°C	ISO 62	%	7

Physical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2350 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	65 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	15 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	14 / -
Rockwell hardness		ISO 2039/2	ScaleR	110 / -

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	175
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	65
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	225

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	Condition	Standard	Unit	Value
Electrical properties				
Volume resistivity		IEC 62631-3-1	ohm.m	1E+016
Surface resistivity		IEC 62631-3-1	ohm	1E+014

Burning behaviour

Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products.
*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	270 - 290 °C
Recommended mould temperature	40 - 80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

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