

TECHNICAL DATA SHEET

TECHNYL A 218 V35 NC

TECHNYL A 218 V35 NC is a polyamide 66, reinforced with 35% of glass fibre, heat stabilized, for injection moulding. This grade offers an excellent combination between thermal and mechanical properties.

General

Feature	Heat-aging stabilized	
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Certification	RoHS EC 1907/2006 (REACH)	UL-Yellow Card
Applications	Automotive Applications Electrical/Electronic Applications Sport	Connectors Outdoor Applications
Colors available	Black	Natural
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-GF35
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Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.41
Water absorption	24 hr, 23°C	ISO 62	%	0.75
Water absorption, saturation			%	5.4
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.35
Molding shrinkage, normal		ISO 294-4, 2577	%	1.1

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	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	11400 / 8700
Stress at break		ISO 527-1/-2	MPa	210 / 150
Strain at break		ISO 527-1/-2	%	3 / 5.5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9500 / 6800
Flexural modulus, ASTM D790	2 mm/min	ASTM D790	MPa	9800 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	290 / -
Flexural strength, ASTM D790	2 mm/min	ASTM D790	MPa	290 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	90 / 100
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	14 / 19
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	80 / 100
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	13 / 18

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	255

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	6E+015
Comparative tracking index	Solution A	IEC 60112	V	400
CTI performance level category		Sol A		PLC 1
Dielectric strength	1 mm	IEC 60243-1	kV/mm	34

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		HB
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Oxygen index			%	23

*: conditioned according to ISO 1110

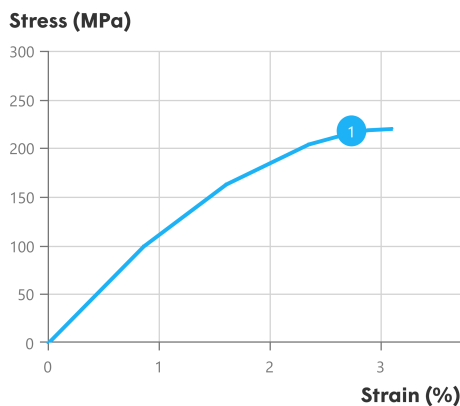
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Processing conditions

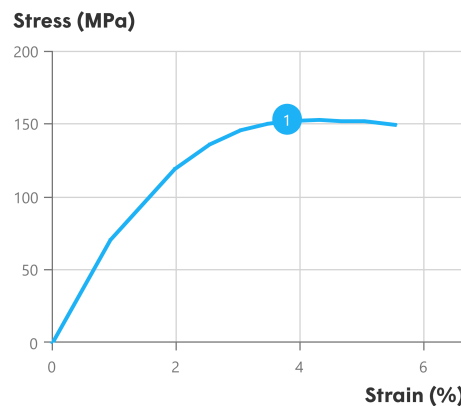
Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	270 - 280 °C
Middle temperature	275 - 285 °C
Front temperature	280 - 290 °C
Recommended mould temperature	70 - 100 °C

Stress-strain, dry



Temperature (°C)	
1	Spannung
1	

Stress-strain, conditioned



Temperature (°C)	
1	Spannung
4	

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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