

TECHNICAL DATA SHEET

TECHNYL AR 218 V25 BK

TECHNYL AR 218 V25 BK is a polyamide 66, reinforced with 25% of glass fiber, heat stabilized, for injection moulding. It contains recycled materials. This grade offers a good 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)
Applications	Automotive Applications Industrial Applications	Consumer good application General Purpose
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-GF25
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Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.32
Water absorption	24 hr, 23°C	ISO 62	%	0.9
Water absorption, saturation			%	6.2

Mechanical properties

dam / cond.*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7800 / 5000
Stress at break		ISO 527-1/-2	MPa	125 / 95
Strain at break		ISO 527-1/-2	%	2.5 / 10
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7200 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	200 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	40 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5.5 / -

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	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	260
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	240

Burning behaviour

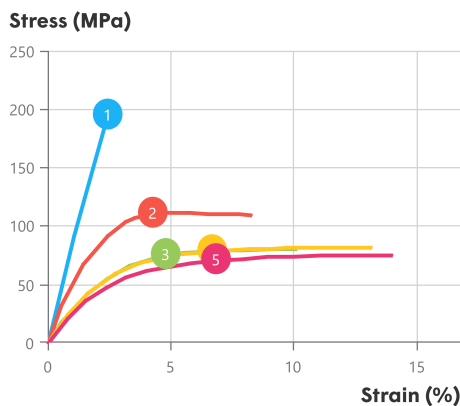
Flammability, 1.5 mm	1.5 mm	UL 94		HB
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*: conditioned according to ISO 1110

Processing conditions

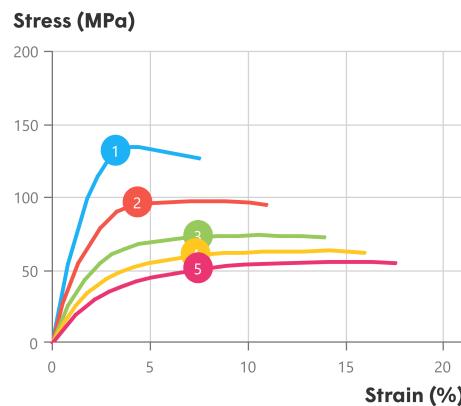
Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	270 - 280 °C
Middle temperature	275 - 285 °C
Front temperature	280 - 290 °C
Recommended mould temperature	70 - 100 °C

Stress-strain, dry



Temperature (°C)	
1	Spannung 1
2	Spannung 3
3	Spannung 4
4	Spannung 5
5	Spannung 6

Stress-strain, conditioned



Temperature (°C)	
1	Spannung 3
2	Spannung 4
3	Spannung 8
4	Spannung 9
5	Spannung 10

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 manufactures 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.