

TECHNYL® A 218 V25 Black LM is a polyamide 66, reinforced with 25% of glass fibre, heat stabilized, for injection moulding. This grade has enhanced properties for applications needing particular laser marking.

GENERAL

Material Status	• Commercial: Active	
Availability	• Asia Pacific	
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight	
Additive	• Heat Stabilizer	
Key Benefits	• Good Dimensional Stability • Good Flow • Heat Aging Resistance	• Heat Stabilized (Inorganic) • Good Mold Release
Applications	• Connectors	• Interior trims and switches
Certification/Compliance	• UL QMFZ2	
RoHS Compliance	• RoHS Compliant	
Colors Available	• Black	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66-GF25	

PROPERTIES

Typical values of properties are for Black grades

Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 294-4
Across Flow	1.1		%	
Flow	0.40		%	
Water Absorption				ISO 62
24 hr, 23°C	0.90		%	
Saturation, 23°C	6.2		%	
Equilibrium, 23°C, 50% RH	2.3		%	
Density	1.32		g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	8900	6000	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	165	100	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	3.0	6.0	%	ISO 527-2
Flexural Modulus				
23°C	7300		MPa	ASTM D790
23°C	7300	5000	MPa	ISO 178



Mechanical	Dry	Conditioned	Unit	Test Method
Flexural Strength (23°C)	250		MPa	ASTM D790
Charpy Notched Impact Strength (23°C)	8.0	12	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	55	78	kJ/m²	ISO 179/1eU
Notched Izod Impact				
23°C	80		J/m	ASTM D256
23°C	8.5	15	kJ/m²	ISO 180
Unnotched Izod Impact Strength (23°C)	55	70	kJ/m²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
1.8 MPa, Unannealed	245		°C	ASTM D648
1.8 MPa, Unannealed	250		°C	ISO 75-2/At
Melting Temperature	262		°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	6.0E+15	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+15	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	32	28	kV/mm	IEC 60243-1
Relative Permittivity	3.70	4.00		IEC 60250
Comparative Tracking Index (Solution A)	400		V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.40 mm	HB			
0.8 mm	HB			
1.6 mm	HB			
Glow Wire Flammability Index (1.6 mm)	650		°C	IEC 60695-2-12
Oxygen Index	23		%	ISO 4589-2

PROCESSING

Injection	Dry	Unit
Drying Temperature	80	°C
Suggested Max Moisture	0.20	%
Rear Temperature	270 to 280	°C
Middle Temperature	275 to 285	°C
Front Temperature	280 to 290	°C
Mold Temperature	70 to 100	°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 mini -20°C. Recommended time 2-4h

Injection Advice:

- For reinforced polyamides, Solvay 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 contained in this document is given in good faith based on our current knowledge. It is only an indication and it is in no way binding. This information must on no account be used as a substitutive for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE IS EXPRESSLY EXCLUDED. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document, and Solvay is at their disposal to supply any additional information.



SAFETY INFORMATION

Detailed information regarding safety are available on the safety data sheet (SDS). SDS is sent with the first material order or available by contacting our customer services

REGULATIONS COMPLIANCE

This product is not intended to be used for the following regulated market: food contact, drinking water, toys, cosmetics or medical devices.

This grade complies with ROHS Directive 2011/65/EU and 2015/863 as amended.

CUSTOMER SERVICES

Our customer services are not only concerned with manufacturing and supply of Engineering Plastics products. We are available to assist our customers in finding technical solutions that meet their requirements. Specific support is in particular offered on:

- Material selection
- Material testing
- Parts design advice, training for design engineers
- Part testing
- Design simulation
- Processing through different technologies
- Assembly and post-processing technology expertise
- Parts optimization through Computer Aided Design

You can find more information on Solvay Product range on our internet product finder at the following address: <http://www.technyl.com>

Notes

Typical properties: these are not to be construed as specifications.

