



TECHNYL A 548B2 V15

(provisional data Sheet)

Description

TECHNYL[®] A 548B2 V15 is a polyamide 6.6, reinforced with 15% of glass fibre, heat stabilized, impact modified, for blow moulding. This product is available in black color.

Key Properties

High viscosity
Very high melt strength
Excellent thermal resistance
Higher lifetime after heat ageing

Benefits

The product offers an excellent long term heat resistance and is suitable to work in environments characterized by a very high temperature. It has been also specially designed to be perfectly suitable for blow moulding processing.

Applications

Thanks to its very high melt strength, this product can be used to produce hollow parts, by suction or 3D blow moulding technology, like tanks or ducts where a long parison is needed. Typical applications are turbo air ducts, especially inlet ducts up to 210°C.

Properties

Typical values of properties are for black grades

	Standards	Unit	Values	
			d.a.m.	Cond.
Physical				
Density	ISO 1183/A	g/cm ³	1,20	
Molding shrinkage Parallel	RHODIA	%	1	
Molding shrinkage normal or perpendicular	RHODIA	%	1	
Molding Shrinkage Isotropy	RHODIA		1	
Mechanical				
Tensile Modulus	ISO 527 Type 1A	MPa	4900	3500
Tensile strength at break	ISO 527 Type 1A	MPa	90	57
Elongation at break	ISO 527 Type 1A	%	4,70	8,80
Flexural modulus	ISO 178	MPa	4200	
Flexural maximum stress	ISO 178	MPa	129	
Charpy notched impact strength (23 °C)	ISO 179/1eA	kJ/m ²	13,5	
Charpy unnotched impact strength (23 °C)	ISO 179/1eU	kJ/m ²	65	79
Thermal				
Melting Temperature	ISO 11357	°C	260	
Heat deflection temperature (1,8 MPa)	ISO 75/Af	°C	210	
Specific				
Identification code				PA66-GF15

d.a.m. = dry as moulded

Cond = conditioned

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 substitute for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANDABILITY 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.

Processing Guide

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.

Recommended Maximum water content: 0,08 %

Drying conditions: 8h at 80°C with dry air, dew point -35°C

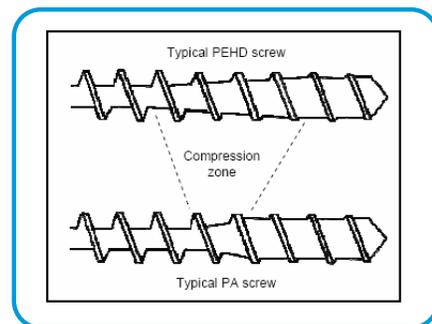
Scrap management

Recommended regrinded scraps use: 20 %

Scrap must be handled carefully and dried prior to usage

Blow-moulding parameters

Temperature (°C)	
Feeding zone:	265 - 285 °C
Screw:	275 - 295 °C
Adapter:	275 - 295 °C
Head:	280 - 300 °C
Die:	280 - 300 °C
Mould:	70 - 90 °C



Blow-moulding machine design

Screw compression rate	3 to 4. Short compression length
Screw type	Pa type (with short transition length, 4D or less) recommended but standard type (with medium transition length, 5 to 7D) acceptable in most cases.
Extrusion technology	Accumulation head recommended. Continuous extrusion acceptable in some cases
Steel advice for tools	For glass fibers reinforced polyamide, Solvay recommends the use of steel with a high content of Carbon and purified for polishing to avoid or limit the abrasion. For example: Z38CDV5W or Z160CDV12.

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

Grades produced or imported in Europe comply with directive 453/2010/EC, which amends REACH directive 1907/2006/EC

This grade complies with RoHS directive 2002/95/EC

Unless specified, this grade is not suitable for food contact, medical devices or toy applications

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
- Processing through different technologies
- Assembly and post-processing technology expertise
- Parts optimization through Computer Aided Design

You can find more information on Solvay/Rhodia Product range on our internet product finder at the following address:

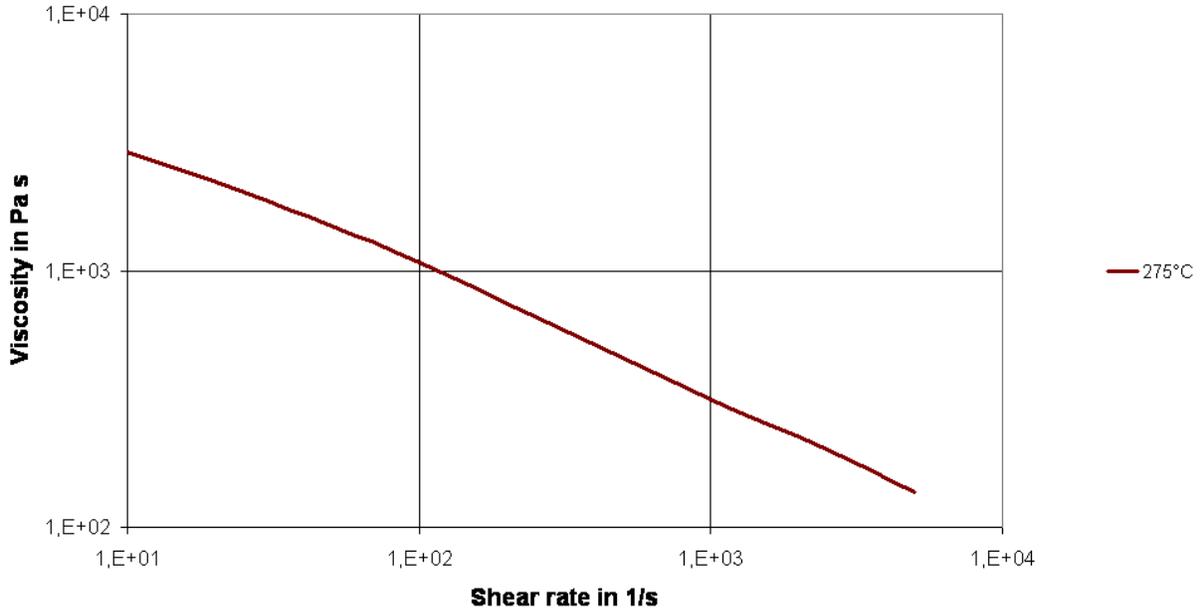
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Viscosity-shear rate

Viscosity-shear rate
Technyl® A 548B2 V15



Stress-strain

Stress-Strain (dry)
Technyl® A 548B2 V15

