

TECHNYL® C 216 MT30 NATURAL

Polyamide 6
Solvay Engineering Plastics

Message:

TECHNYL® C 216 MT30 Natural is a polyamide 6, reinforced with 30% of mineral filler, for injection moulding. The isotropic shrinkage and the good dimensional stability make it adequate for every kind of application in which the planarity of the part is important.

General Information				
Filler / Reinforcement		Mineral filler, 30% filler by weight		
Features		Good dimensional stability		
		Low warpage		
		Good demoulding performance		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS compliance		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
Resin ID (ISO 1043)		PA6-MD30		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
23°C, 24 hr	1.0	--	%	ISO 62
Saturated, 23°C	6.1	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	5500	2500	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	85.0	50.0	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	6.0	55	%	ISO 527-2
Flexural Modulus (23°C)	5300	2000	MPa	ISO 178
Flexural Stress (23°C)	115	57.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Notched Izod Impact (23°C)	5.0	15	kJ/m ²	ISO 180
Unnotched Izod Impact Strength (23°C)	> 200	> 200	kJ/m ²	ISO 180/1U

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	140	--	°C	ISO 75-2/Af
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+13	ohms·cm	IEC 60093
Dielectric Strength (2.00 mm)	25	15	kV/mm	IEC 60243-1
Dissipation Factor	0.020	0.090		IEC 60250
Flammability	Dry	Conditioned	Unit	Test Method
Glow Wire Flammability Index (1.6 mm)	850	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	230 - 235		°C	
Middle Temperature	235 - 240		°C	
Front Temperature	240 - 250		°C	
Mold Temperature	60 - 90		°C	
Injection instructions				

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 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: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 /1.2379 (DIN Norm). For Mould Temperature, in the case of parts where the surface roughness is required we can recommend a temperature of 90°C to 120°C with an optimum at 105°C.

The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design

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