

Stanyl® TW250F6

Polyamide 46
DSM Engineering Plastics

Message:

Stanyl® TW250F6 is a Polyamide 46 (Nylon 46) material filled with 30% glass fiber. It is available in Europe.
Important attributes of Stanyl® TW250F6 are:
Flame Rated
Flame Retardant
Heat Stabilizer

General Information				
UL YellowCard		E47960-240077	E172082-538630	
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Additive		Flame Retardant		
		Heat Stabilizer		
Features		Flame Retardant		
		Heat Stabilized		
Forms		Pellets		
Multi-Point Data		Isochronous Stress vs. Strain (ISO 11403-1)		
		Shear Modulus vs. Temperature (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.68	--	g/cm³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.1	--	%	
Flow	0.40	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.6	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus				ISO 527-2
--	12000	8000	MPa	
120°C	7500	--	MPa	
160°C	6200	--	MPa	
Tensile Stress				ISO 527-2
Break	180	125	MPa	
Break, 120°C	105	--	MPa	
Break, 160°C	95.0	--	MPa	
Tensile Strain				ISO 527-2
Break	2.5	3.5	%	

Break, 120°C	4.0	--	%	
Break, 160°C	4.0	--	%	
Flexural Modulus				ISO 178
--	11000	7300	MPa	
120°C	6500	--	MPa	
160°C	5000	--	MPa	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	10	10	kJ/m ²	
23°C	11	11	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	50	50	kJ/m ²	
23°C	60	60	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
-40°C	11	11	kJ/m ²	
23°C	11	11	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	290	--	°C	ISO 75-2/A
Melting Temperature ¹	295	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	2.5E-5	--	cm/cm/°C	
Transverse	5.5E-5	--	cm/cm/°C	
Thermal Index - 5000 hr	177	--	°C	IEC 60216
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+14	1.0E+8	ohms·cm	IEC 60093
Electric Strength	30	--	kV/mm	IEC 60243-1
Comparative Tracking Index	175	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	V-0	--		
1.50 mm	V-0	--		
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	280 to 320		°C	
Middle Temperature	300 to 320		°C	
Front Temperature	300 to 320		°C	
Nozzle Temperature	300 to 320		°C	

Processing (Melt) Temp	305 to 320	°C
Mold Temperature	80.0 to 120	°C
Injection Rate	Moderate-Fast	
Back Pressure	2.00 to 10.0	MPa
Screw Compression Ratio	2.5:1.0	

NOTE

1. 10°C/min

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