

TECHNYL® C 206F NATURAL (R)

Polyamide 6

Solvay Engineering Plastics

Message:

TECHNYL® C 206F Natural (R) is an unreinforced polyamide PA6, standard for fast injection cycles, for injection moulding. This grade has high fluidity and a good mould release.

General Information				
UL YellowCard		E44716-235518		
Features		Fast molding cycle		
		Good liquidity		
		Good demoulding performance		
Uses		Valve/valve components		
		Fasteners		
		Accessories		
Agency Ratings		EC 1907/2006 (REACH)		
		UL QMFZ2		
RoHS Compliance		RoHS compliance		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA6		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183/A
Molding Shrinkage				ISO 294-4
Transverse flow	0.35	--	%	ISO 294-4
Flow	0.65	--	%	ISO 294-4
Water Absorption				ISO 62
23°C, 24 hr	1.3	--	%	ISO 62
Saturated, 23°C	2.7	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.6	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3000	1100	MPa	ISO 527-2/1A
Tensile Stress				ISO 527-2/1A
Yield, 23°C	85.0	45.0	MPa	ISO 527-2/1A
Fracture, 23°C	50.0	60.0	MPa	ISO 527-2/1A
Tensile Strain				ISO 527-2

Yield, 23°C	4.0	30	%	ISO 527-2
Fracture, 23°C	15	> 200	%	ISO 527-2
Flexural Modulus (23°C)	2800	1000	MPa	ISO 178
Flexural Stress (23°C)	100	40.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	88	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	80	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	60.0	--	°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)	--	18	kV/mm	IEC 60243-1
Relative Permittivity	3.40	3.90		IEC 60250
Dissipation Factor	0.023	0.10		IEC 60250
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm)	V-2	--		UL 94
Glow Wire Ignition Temperature (0.8 mm)	675	--	°C	IEC 60695-2-13
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	230 - 235		°C	
Middle Temperature	235 - 240		°C	
Front Temperature	235 - 245		°C	
Mold Temperature	60 - 80		°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 unfilled polyamide, Solvay recommends the use of high alloy steel with a weak chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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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