

TECHNYL® A 218 V35 Y10 NATURAL

Polyamide 66
Solvay Engineering Plastics

Message:

TECHNYL® A 218 V35 Y10 Natural is a polyamide 66, reinforced with 35% of glass fiber, heat stabilized and specially modified to have improved frictional properties, for injection moulding. This grade offers an excellent combination between thermal and mechanical properties.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Additive		heat stabilizer		
Features		Heat Stabilized - Inorganic		
		Low friction coefficient		
		Good liquidity		
		Good demoulding performance		
Uses		Gear		
		Large household appliances and small household appliances		
Agency Ratings		UL QMFZ2		
RoHS Compliance		RoHS compliance		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA66-GF35		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.42	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
23°C, 24 hr	0.65	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.5	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	12700	8700	MPa	ISO 527-2/1A
Tensile Strength				
Yield, 23°C	185	128	MPa	ASTM D638
Fracture, 23°C	204	133	MPa	ISO 527-2/1A
Tensile Elongation				
Fracture, 23°C	2.7	5.5	%	ASTM D638
Fracture, 23°C	2.6	5.0	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	13	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength (23°C)	72	80	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	11	13	kJ/m ²	ISO 180
Unnotched Izod Impact (23°C)	80.0	100	kJ/m ²	ASTM D256
Unnotched Izod Impact Strength (23°C)	60	75	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	--	°C	ISO 75-2/Af
Melting Temperature	262	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	270 - 280		°C	
Middle Temperature	275 - 285		°C	
Front Temperature	280 - 290		°C	
Mold Temperature	70 - 100		°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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