

TECHNYL® C 218 MZ20 V10 BLACK

Polyamide 6

Solvay Engineering Plastics

Message:

TECHNYL® C 218 MZ20 V10 Black is a polyamide 6, reinforced 20 % mineral filler and 10 % of glass fibre, heat stabilized, for injection moulding. This grade offers an excellent planarity of the end product, good mechanical properties and a high dimensional stability.

General Information				
Filler / Reinforcement	Glass \mineral, 30% filler by weight			
Additive	heat stabilizer			
Features	Heat Stabilized - Inorganic Good dimensional stability Low warpage Rigid, good			
Uses	Application in Automobile Field			
RoHS Compliance	RoHS compliance			
Appearance	Black			
Forms	Particle			
Processing Method	Injection molding			
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)			
Resin ID (ISO 1043)	PA6-MD20+GF10			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	7400	4500	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	100	60.0	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	3.3	--	%	ISO 527-2
Flexural Modulus (23°C)	9300	--	MPa	ISO 178
Flexural Stress (23°C)	255	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	14	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	85	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	15	--	kJ/m ²	ISO 180
Unnotched Izod Impact Strength (23°C)	82	--	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature (1.8 MPa, Unannealed)	205	--	°C	ISO 75-2/Af
Melting Temperature	222	--	°C	ISO 11357-3
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.

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