

# TECHNYL® A 238J1 NATURAL

Polyamide 66  
Solvay Engineering Plastics

Message:

TECHNYL ® A 238J1 Natural is an unfilled polyamide 6.6, heat stabilized, impact modified, for injection moulding. This grade offers excellent combination between rigidity and impact resistance at ambient temperature.

General Information			
Additive	Impact modifier		
	heat stabilizer		
Features	Heat Stabilized - Inorganic		
	Impact resistance, high		
	Good demoulding performance		
Uses	Industrial application		
	Connector		
	Application in Automobile Field		
	Consumer goods application field		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	70.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Suggested Max Moisture	0.20	%	
Rear Temperature	265 - 275	°C	
Middle Temperature	270 - 280	°C	
Front Temperature	280 - 285	°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 2-4hInjection 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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#### Recommended distributors for this material

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