

**TECHNYL® D 247F NC**

 DOMO Engineering Plastics - *Polyamide 610 + PA 66*
**General Information**
**Product Description**

TECHNYL D 247F NC is an unfilled grade based on polyamide blend of polyamide 6.10 and polyamide 66, heatstabilized, impact modified, for injection moulding. This grade has been designed to offer high impact strength, alkaliresistance and excellent productivity. It is a partially bio-sourced materia

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Additive	• Impact Modifier • Mold Release
Features	• Excellent Processability • Impact Modified
Uses	• Consumer Applications • Industrial Applications
Agency Ratings	• EC 1907/2006 (REACH)
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding
ISO Designation (ISO 16396)	• PA66+PA610,0,M1,S14-020
Resin ID (ISO 1043)	• PA66+PA610

**Properties <sup>1</sup>**

Physical	Dry	Conditioned	Unit	Test Method
Density	1.07	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.90 to 1.1	--	%	
Flow	1.3 to 1.5	--	%	
Water Absorption (24 hr, 73°F)	0.60 to 0.70	--	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	1.4	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	348000	189000	psi	ISO 527-1
Tensile Stress (Yield)	8700	--	psi	ISO 527-2
Tensile Strain (Break)	35	--	%	ISO 527-2
Flexural Modulus	312000	189000	psi	ISO 178
Flexural Stress	11600	6530	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	5.2	--	ft-lb/in <sup>2</sup>	
73°F	5.2	9.5	ft-lb/in <sup>2</sup>	
Notched Izod Impact Strength (73°F)	10	--	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	111	--		ISO 2039-2
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	284	--	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	140	--	°F	ISO 75-2/A
Melting Temperature <sup>2</sup>	504	--	°F	ISO 11357-3
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.12 in)	HB	--		UL 94

**Processing Information**

Injection	Dry Unit
Drying Temperature	176 °F



Suggested Max Moisture	0.20 %
Rear Temperature	500 to 518 °F
Middle Temperature	509 to 527 °F
Front Temperature	518 to 536 °F
Mold Temperature	140 to 176 °F

#### Injection Notes

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 minimum -20°C. Recommended time 2-4h.

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 10°C/min

