

TECHNICAL DATA SHEET

TECHNYL AC 216 BK XB

TECHNYL AC 216 BK XB is an unfilled blend polyamide 66 and 6, for injection moulding. This grade offers an improved surface finished.

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA66 + PA6	
Feature	improved surface finish	
Applications	small appliance	consumer applications
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66+PA6
ISO 16396 designation	PA66+PA6,M,S14-030

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.14
Water absorption	24 hr, 23°C	ISO 62	%	1.6

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3500 / -
Strain at break		ISO 527-1/-2	%	75 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2700 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	110 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	4 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	257
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	200
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	60

	Condition	Standard	Unit	Value
Burning behaviour				
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		<100 mm/min

Processing conditions	
Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Suggested max moisture	0.2 %
Rear temperature	260 - 270 °C
Middle temperature	265 - 275 °C
Front temperature	265 - 275 °C
Recommended mould temperature	60 - 80 °C

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.

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Injection advice

All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, Domo recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, Domo advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design.