

TECHNICAL DATA SHEET

## TECHNYL AR1 218S V30 BK

TECHNYL AR1 218S V30 BK is a blend polyamide 66 and 6, wide specs, reinforced with 30% of glass fiber, heat stabilised for injection Moulding.

### General

Polymer type	PA66 + PA6		
Certifications	RoHS	EC 1907/2006 (REACH)	
Feature	heat-aging stabilized second choice	improved surface finish	
Colors available	black		
Forms	pellets		

### Product identification

ISO 1043 abbreviation	PA66 + PA6-GF30		
ISO 16396 designation	PA66,GF30,MH,S14-070		

Condition	Standard	Unit	Value
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### Physical properties

	Condition	Standard	Unit	Value
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23°C	ISO 62	%	1.4 - 1.5
Water absorption, saturation			%	6.1

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8000 / -
Stress at break		ISO 527-1/-2	MPa	150 / -
Strain at break		ISO 527-1/-2	%	2.4 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	50 / -

\*: **conditioned according to ISO 1110**

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

### Processing conditions

Drying temperature/time	80°C
Suggested max moisture	0.2 %
Rear temperature	270 - 280 °C
Middle temperature	275 - 285 °C
Front temperature	280 - 290 °C
Recommended mould temperature	70 - 100 °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.

### Injection advice

For reinforced polyamides, Domo 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). 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.