

TECHNICAL DATA SHEET

## TECHNYL B 218L V20 GY 2527A CF

TECHNYL B 218L V20 GY 2527A CF is a copolyamide 66/6, reinforced with 20% of glass fibre, heat stabilized with improved UV ageing resistance, for injection moulding. This grade offers an excellent combination of thermal and mechanical properties, good surface aspect and good UV resistance.

### General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA66/6 copolymer	
Feature	heat-aging stabilized good surface finish	UV stabilized weather resistant
Applications	automotive applications outdoor applications	handles
Colors available	black	grey
Forms	pellets	
Processing technology	injection moulding	

### Product identification

ISO 1043 abbreviation	PA66/6-GF20
ISO 16396 designation	PA66/6,GF20,MHL1,S14-070

Condition	Standard	Unit	Value
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### Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.29
Water absorption	24 hr, 23°C	ISO 62	%	1.2 - 1.3

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7000 / 4500
Stress at break		ISO 527-1/-2	MPa	120 / 80
Strain at break		ISO 527-1/-2	%	2.1 / 9
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5800 / 3500
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	30 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	3.2 / -

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

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	242
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	211

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Oxygen index			%	23.0
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

<b>Processing conditions</b>	
Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	255 - 265 °C
Middle temperature	260 - 270 °C
Front temperature	270 - 280 °C
Recommended mould temperature	70 - 100 °C

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## 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.