

TECHNICAL DATA SHEET

TECHNYL RED A 218HPS V50 BK 21N



TECHNYL RED A 218HPS V50 BK 21N is a polyamide blend of polyamide 6.6 polyamide 6 reinforced with 50% of glass fiber, high heat stabilized for injection moulding. This grade is designed to offer a long term heat resistance and is suitable to work in environments characterized by a very high temperature (210°C).

General

Polymer type	PA66 + PA6		
Certifications	RoHS	EC 1907/2006 (REACH)	
Feature	heat-aging stabilized heat resistant	good surface finish high stiffness	
Applications	automotive applications		
Colors available	black		
Forms	pellets		
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA66+PA6-GF50
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Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.56
Water absorption	24 hr, 23°C	ISO 62	%	0.1 - 0.2
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	0.45

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	17500 / 10400
Stress at break		ISO 527-1/-2	MPa	238 / 154
Strain at break		ISO 527-1/-2	%	2.7 / 5.4
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	14000 / 9440
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	368 / 252
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	97 / -
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	100 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	18 / 25
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	16 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	250
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	254
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	232

	Condition	Standard	Unit	Value
Burning behaviour				
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	280 - 290 °C
Front temperature	280 - 300 °C

Processing conditions

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.