

TECHNICAL DATA SHEET

TECHNYL A 422 NC FL

TECHNYL A 422 NC FL is an unreinforced polyamide PA66 medium viscosity for injection moulding. It is used for consumers and industrial goods applications and is particularly suitable for injection molding of thick parts.

General

Polymer type	PA66		
Certifications	RoHS	EC 1907/2006 (REACH)	
Feature	impact modified very high flow	balanced stiffness/toughness	
Applications	consumer applications	industrial applications	
Colors available	natural		
Forms	pellets		
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA66
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Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.14
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Condition	Standard	Unit	Value
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Mechanical properties

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Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3200 / -
Stress at break		ISO 527-1/-2	MPa	50 / -
Strain at break		ISO 527-1/-2	%	30 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / -

*: **conditioned according to ISO 1110**

Condition	Standard	Unit	Value
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Thermal properties

Condition	Standard	Unit	Value
Melting temperature, 10°C/min	ISO 11357-1	°C	263

Condition	Standard	Unit	Value
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Burning behaviour

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

Condition	Standard	Unit	Value
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Electrical properties

Condition	Standard	Unit	Value	
Dielectric strength	1 mm	IEC 60243-1	kV/mm	22.0

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	265 - 275 °C
Middle temperature	270 - 280 °C
Front temperature	280 - 285 °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.

Injection advice

For unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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.