

TECHNICAL DATA SHEET

TECHNYL A 218Z V30 BK 34 N

TECHNYL A 218Z V30 BK 34 N is a polyamide 66, reinforced with 30% of glass fibre, heat stabilized. This grade has been developed for injection moulding using gas injection technology. This grade combines short time cycle and excellent internal surface aspect.

General

Certifications	RoHS	EN 45545
Polymer type	PA66	
Feature	heat-aging stabilized	good surface finish
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66-GF30
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Condition	Standard	Unit	Value
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Physical properties

	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.34
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.45
Molding shrinkage, normal	ISO 294-4, 2577	%	1.9

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8000 / -
Stress at break		ISO 527-1/-2	MPa	140 / -
Strain at break		ISO 527-1/-2	%	3 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7200 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	220 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	45 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	4.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	50 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	240

	Condition	Standard	Unit	Value
Burning behaviour				
Flammability, 1.5 mm	1.5 mm	UL 94		HB

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

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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.