

TECHNICAL DATA SHEET

TECHNYL AR 130/GF BK

TECHNYL AR 130/GF BK is a polyamide 66, reinforced with 30% of glass fiber, heat stabilized, for injection moulding. This grade offers a good combination between thermal and mechanical properties. This product is not suitable for hot runners. Its properties may vary over a larger range than a material made from virgin raw materials.

General

Polymer type	PA66
Certifications	RoHS EC 1907/2006 (REACH)
Feature	heat-aging stabilized
Applications	general purpose
Colors available	black
Forms	pellets
Processing technology	injection moulding

Product identification

ISO 1043 abbreviation	PA66-GF30
ISO 16396 designation	PA66,GF30,M,S14-070

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.37
Water absorption	24 hr, 23°C	ISO 62	%	0.8

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9500 / 6000
Stress at break		ISO 527-1/-2	MPa	170 / 95
Strain at break		ISO 527-1/-2	%	2.3 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8250 / 5500
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	245 / 140
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	45 / 65
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	6 / 9
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	38 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	260
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	260
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	245

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

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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. Not suitable for hot runners.