TECHNYL® SHAPE
For extrusion & blow molding

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL SHAPE A 548B V15 BK 23N

TECHNYL A 548B V15 BLACK 23N

TECHNYL SHAPE A 548B V15 BK 23N is a polyamide 66 reinforced with 15% of glass fibre, heat stabilized, impact modified, for blow moulding. This grade offers an excellent long term Heat resistance and is suitable to work in environments characterized by a very high temperature. It has been also specially designed to be perfectly suitable for blow moulding processing.

General

Polymer type	PA66	
Certifications	RoHS	EC 1907/2006 (REACH)
Feature	high viscosity high melt strength	high impact resistant
Applications	automotive applications	
Colors available	black	
Forms	pellets	
Processing technology	blow moulding	

Product identification

ISO 1043 abbreviation	PA66-GF15

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.2

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5200 / 3500
Stress at break		ISO 527-1/-2	MPa	100 / 60
Strain at break		ISO 527-1/-2	%	5 / 9
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4100 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	130 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	68 / 80
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	11 / 20
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	58 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	13 / -

: conditioned according to ISO 1110

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	242
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	215

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

Processing conditions	
Drying temperature/time	8H at 80°C with dry air, dew point -35°C
Suggested max moisture	0.08 %
Feed zone temperature for blow-molding	250 - 270 °C
Screw temperature for blow-molding	255 - 275 °C
Adapter temperature for blow-molding	260 - 280 °C
Head temperature for blow-molding	270 - 290 °C

Processing conditions

Die temperature for blow-molding	270 - 290 °C
Mold temperature for blow molding	60 - 80 °C