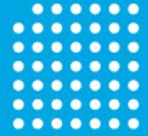


TECHNICAL DATA SHEET

**TECHNYL STAR AFX 216 V50 GY 2684**



TECHNYL STAR AFX 216 V50 GY 2684 is a high flow polyamide 66 resin, reinforced with 50% of glass fibre, for injection moulding. Due to its outstanding flow characteristics, this grade shows exceptional processing behaviour and excellent surface aspect of the finished part.

**General**

Polymer type	PA66	
Feature	excellent surface finish high stiffness	high dimensional stability very high flow
Applications	gears white goods / small appliances	living hinges
Colors available	grey	
Forms	pellets	
Processing technology	injection moulding	

**Product identification**

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

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.57
Water absorption	24 hr, 23°C	ISO 62	%	0.6
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.25
Molding shrinkage, normal		ISO 294-4, 2577	%	0.5

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	17000 / 12500
Stress at break		ISO 527-1/-2	MPa	255 / 180
Strain at break		ISO 527-1/-2	%	2.5 / 3.5
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	100 / 100
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	15 / 21

\*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	264
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	256

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

<b>Processing conditions</b>	
Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	265 - 275 °C
Middle temperature	270 - 280 °C
Front temperature	280 - 290 °C
Recommended mould temperature	60 - 90 °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 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.