

TECHNICAL DATA SHEET

TECHNYL SHAPE A 548B2 V15 BK 23N
TECHNYL A 548B2 V15 BLACK 23N



TECHNYL SHAPE A 548B2 V15 BK 23N is a polyamide 6.6, 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	heat-aging stabilized high melt strength	high viscosity	
Applications	automotive applications		
Colors available	black		
Forms	pellets		
Processing technology	blow moulding		

Product identification

ISO 1043 abbreviation	PA66-GF15
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Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.2
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.35
Molding shrinkage, normal		ISO 294-4, 2577	%	1.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	4900 / 3000
Stress at break		ISO 527-1/-2	MPa	90 / 57
Strain at break		ISO 527-1/-2	%	4.7 / 8.8
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4500 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	145 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	65 / 79
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	14 / -

*: **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, 1.80 MPa	1.80 MPa	ISO 75	°C	210

	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	260 - 280 °C
Screw temperature for blow-molding	270 - 290 °C
Adapter temperature for blow-molding	275 - 295 °C
Head temperature for blow-molding	280 - 300 °C
Die temperature for blow-molding	280 - 300 °C
Mold temperature for blow molding	70 - 90 °C

Processing conditions

Recommended blow-molding temperature	250 - 290 °C
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