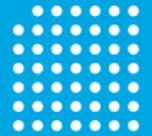


TECHNICAL DATA SHEET

TECHNYL STAR S 218 V30 NC



TECHNYL STAR S 218 V30 NC is based on a patented high flow polyamide 6 resin (TechnylStar), heat stabilized, reinforced with 30% of glass fibre, for injection moulding. Due to its outstanding flow characteristics, this grade provides a significant productivity improvement and allows more freedom in mould and part design versus a standard polyamide solutions.

General

Polymer type	PA6	
Certifications	RoHS EC 1907/2006 (REACH)	UL listed product
Feature	heat-aging stabilized very high flow	excellent surface finish
Applications	consumer applications general purpose	home & office furniture industrial applications
Colors available	natural	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-GF30
ISO 16396 designation	PA6,GF30,MH,S12-100

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.35
Water absorption	24 hr, 23°C	ISO 62	%	0.9 - 1.0
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.1 - 0.2
Molding shrinkage, normal		ISO 294-4, 2577	%	0.9 - 1.1

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10000 / 6000
Stress at break		ISO 527-1/-2	MPa	190 / 110
Strain at break		ISO 527-1/-2	%	3 / 5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9000 / 5300
Flexural modulus, ASTM D790	2 mm/min	ASTM D790	MPa	8650 / 5000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	250 / 160
Flexural strength, ASTM D790	2 mm/min	ASTM D790	MPa	255 / 150
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	75 / 80
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	12 / 15
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	12 / 16
Izod notched impact strength, -30°C	-30°C	ISO 180/1A	kJ/m ²	12 / 14

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	221
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	208

	Condition	Standard	Unit	Value
Burning behaviour				
UL Yellow Card availability 1	<u>Click here to have access to the UL Yellow Card availability 1 -> QMFZ2.E44716</u>			
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	650
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Condition	Standard	Unit	Value
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Electrical properties

Comparative tracking index	Solution A	IEC 60112	V	400.0
CTI performance level category		Sol A		PLC 1

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	240 - 245 °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.