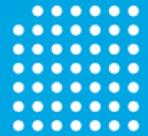


TECHNICAL DATA SHEET

**TECHNYL STAR S 218 V35 NC**



TECHNYL STAR S 218 V35 NC is based on a patented high flow polyamide 6 resin (TechnylStar), heat stabilized, reinforced with 35% 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**

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

**Product identification**

ISO 1043 abbreviation	PA6-GF35
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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>	1.41
Water absorption	24 hr, 23°C	ISO 62	%	0.9
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.1
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	11000 / 7400
Stress at break		ISO 527-1/-2	MPa	195 / 115
Strain at break		ISO 527-1/-2	%	3 / 4
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	10000 / 6200
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	285 / 195
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	60 / 70
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	11 / 16
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m <sup>2</sup>	75 / 80
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	11 / 16

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

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	222
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	210

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
UL Yellow Card availability 1		<a href="#"><b>Click here to have access to the UL Yellow Card availability 1 -&gt; QMFZ2.E44716</b></a>		
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

**Processing conditions**

Drying temperature/time	80 °C
Suggested max moisture	0.2 %

### Processing conditions

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.