

TECHNYL® eXten D 247F NATURAL

Polyamide 66/610 Copolymer

Solvay Engineering Plastics

Message:

Polyamide 66 & 610, impact modified, alkali resistance, mold release, for injection molding

General Information			
Additive	Impact Modifier		
	Mold Release		
Features	Alkali Resistant		
	Good Mold Release		
	Good Processability		
	High Impact Resistance		
	Impact Modified		
Uses	Gaskets		
Appearance	Colors Available		
	Natural Color		
Processing Method	Injection Molding		
Part Marking Code (ISO 11469)	>PA66+PA610<		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	60.0	MPa	ASTM D638
Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus	2600	MPa	ASTM D790
Flexural Strength (Break)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	68.0	°C	ASTM D648
Melting Temperature	262	°C	ISO 11357-3
Heat Deflection Temperature - 0.64 MPa	182	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Suggested Max Moisture	0.20	%
Rear Temperature	265 to 270	°C
Middle Temperature	270 to 280	°C
Front Temperature	280 to 290	°C
Mold Temperature	60.0 to 80.0	°C

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