

TECHNYL® B 738 MX15 GREY 3279

Polyamide 66/6 Copolymer

Solvay Engineering Plastics

Message:

TECHNYL B 738 MX15 Grey 3279 is a copolyamide 6.6, reinforced with 15% of mineral filler, for injection moulding. This grade offers good mechanical Properties, good superficial aspect and dimensional stability.

General Information				
Filler / Reinforcement		Mineral filler, 15% filler by weight		
Additive		heat stabilizer		
Features		Heat Stabilized - Inorganic		
		Good dimensional stability		
		Excellent appearance		
Uses		Electrical/Electronic Applications		
		Application in Automobile Field		
Appearance		Black		
		Grey		
Forms		Particle		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA66/6-MD15		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.22	--	g/cm ³	ISO 1183/A
Water Absorption (23°C, 24 hr)	1.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	4300	--	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	59.0	--	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	3.0	--	%	ISO 527-2
Flexural Modulus (23°C)	3700	--	MPa	ISO 178
Flexural Stress (23°C)	100	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	60	--	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature	242	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	

Rear Temperature	255 - 265	°C
Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Mold Temperature	70 - 100	°C

Injection instructions

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 mini -20°C. Recommended time 2-4h

Injection Advice:

For reinforced polyamide, Solvay 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). For Mould Temperature, in the case of parts where the surface roughness is required we can recommend a temperature of 90°C to 120°C with an optimum at 105°C.

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