TECHNYL® C 216 V45 NATURAL

Polyamide 6

Solvay Engineering Plastics

Message:

TECHNYL® C 216 V45 Natural is a polyamide 6, reinforced with 45% of glass fibre, for injection moulding. This grade has been optimized to have good impact strength, a nice surface aspect and being easy to paint.

General Information	
Filler / Reinforcement	Glass fiber reinforced material, 45% filler by weight
Features	Good dimensional stability Rigidity, high Good liquidity Good demoulding performance
Uses	Power/other tools Sporting goods Consumer goods application field
Agency Ratings	EC 1907/2006 (REACH)
RoHS Compliance	RoHS compliance
Appearance	Black Natural color
Forms	Particle
Processing Method	Injection molding
Resin ID (ISO 1043)	PA6-GF45

Physical	Dry	Conditioned	Unit	Test Method
Density	1.51	--	g/cm³	ISO 1183/A
Water Absorption (23°C, 24 hr)	0.80	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus (23°C)	13000	8300	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	190	145	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	2.5	--	%	ISO 527-2
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	13	26	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	90	--	kJ/m²	ISO 179/1eU
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**

Heat Deflection Temperature (1.8 MPa, Unannealed)	210	--	°C	ISO 75-2/Af
Melting Temperature	222	--	°C	ISO 11357-3

Injection	Dry	Unit	
Drying Temperature	80		°C
Suggested Max Moisture	0.20		%
Rear Temperature	235 - 240		°C
Middle Temperature	240 - 250		°C
Front Temperature	250 - 260		°C
Mold Temperature	60 - 90		°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 2-4hInjection 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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