TECHNYL STAR® AF 219 V35 BLACK

Polyamide 66

Solvay Engineering Plastics

Message:

TECHNYL STAR® AF 219 V35 Black is a polyamide 6.6, high flow, reinforced with 35% of glass fiber, heat stabilized with organic stabilizers, for injection moulding. Due to its outstanding flow caracteristics, this grade shows exceptional processing behaviour and excellent surface aspect of the finished part. This grade restricts electrolytic corrosion. This grade is ideal for Mucell® injection moulding technology.

General Information	
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight
Additive	heat stabilizer
Features	Heat Stabilized - Organic Low Halogen Content Excellent appearance High liquidity Good demoulding performance
Uses	Connector Application in Automobile Field General
Agency Ratings	EC 1907/2006 (REACH)
RoHS Compliance	RoHS compliance
Appearance	Black
Forms	Particle
Processing Method	MuCell® Injection Molding Injection molding
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1) Viscosity vs. Shear Rate (ISO 11403-2)
Resin ID (ISO 1043)	PA66-GF35

Physical	Dry	Conditioned	Unit	Test Method
Density	1.38	--	g/cm³	ISO 1183/A
Water Absorption				ISO 62
23°C, 24 hr	0.75	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	--	%	ISO 62

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	11600	7500	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	190	115	MPa	ISO 527-2/1A

Tensile Strain (Break, 23°C)	2.6	7.4	%	ISO 527-2
Flexural Modulus (23°C)	10400	10100	MPa	ISO 178
Flexural Stress (23°C)	270	190	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.8	11	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength				
23°C	60	77	kJ/m^2	ISO 179/1eU
23°C	48	67	kJ/m^2	ISO 179/1fU
Unnotched Izod Impact Strength (23°C)	55	--	kJ/m^2	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	245	--	°C	ISO 75-2/Af
Melting Temperature	257	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	265 - 275		°C	
Middle Temperature	270 - 280		°C	
Front Temperature	280 - 290		°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.
The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design

Recommended distributors for this material

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Email: sales@su-jiao.com

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