TECHNYL® A 238J1 BLACK 21

Polyamide 66

Solvay Engineering Plastics

Message:

TECHNYL ® A 238J1 Black 21 is an unfilled polyamide 6.6, heat stabilized, impact modified, for injection moulding. This grade offers excellent combination between rigidity and impact resistance at ambient temperature.

General Information			
Additive	Impact modifier		
Features	Heat Stabilized - Inorganic Impact resistance, high Good demoulding performance		
Uses	Industrial application Connector Application in Automobile Field Consumer goods application field		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Appearance	Black Natural color		
Forms	Particle		
Processing Method	Injection molding		
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	70.0	°C	ISO 75-2/Af
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80	°C	
Suggested Max Moisture	0.20	%	
Rear Temperature	265 - 275	°C	
Middle Temperature	270 - 280	°C	
Front Temperature	280 - 285	°C	
Mold Temperature	60 - 80	°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 unfilled polyamide, Solvay recommends the use of high alloy steel with a weak chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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

Susheng Import & Export Trading Co.,Ltd.

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