

TECHNYL® C 218 V35 NATURAL

Polyamide 6
Solvay Engineering Plastics

Message:

TECHNYL® C 218 V35 Natural is a polyamide 6, reinforced with 35% of glass fiber, heat stabilized, for injection moulding. The product offers an excellent combination between thermal and mechanical properties.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Additive		heat stabilizer		
Features		Good dimensional stability		
		Good liquidity		
		Good demoulding performance		
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-GF35		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.41	--	g/cm ³	ISO 1183/A
Water Absorption (23°C, 24 hr)	0.90	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10600	6900	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	195	115	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	3.0	7.0	%	ISO 527-2
Flexural Modulus (23°C)	9600	6000	MPa	ISO 178
Flexural Stress (23°C)	280	185	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	17	19	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	83	94	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	15	28	kJ/m ²	ISO 180
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
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+13	ohms·cm	IEC 60093
Dielectric Strength (2.00 mm)	--	22	kV/mm	IEC 60243-1
Dissipation Factor	0.020	0.090		IEC 60250
Comparative Tracking Index (Solution A)	550	475	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Glow Wire Flammability Index				IEC 60695-2-12
1.6 mm	650	--	°C	IEC 60695-2-12
3.2 mm	650	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	230 - 235		°C	
Middle Temperature	235 - 240		°C	
Front Temperature	240 - 250		°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 2-4h

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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