

TECHNYL® C 216 V30 BLUE 2234 CF

Polyamide 6
Solvay Engineering Plastics

Message:

TECHNYL® C 216 V30 Blue 2234CF is a polyamide 6, reinforced with 30% of glass fibre, for injection moulding. This grade has good mechanical properties and offering an excellent combination between thermal and mechanical properties.

General Information				
UL YellowCard		E44716-235521		
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Features		Good liquidity		
		Good demoulding performance		
Uses		Power/other tools		
		Sporting goods		
		General		
Agency Ratings		EC 1907/2006 (REACH)		
		UL QMFZ2		
Appearance		Black		
		Grey		
		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA6-GF30		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
23°C, 24 hr	1.1	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	9600	6400	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	145	94.0	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	2.1	3.7	%	ISO 527-2
Flexural Modulus (23°C)	7000	4600	MPa	ISO 178
Flexural Stress (23°C)	205	135	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method

Charpy Unnotched Impact Strength (23°C)	25	40	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	218	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	200	--	°C	ISO 75-2/Af
Melting Temperature	222	--	°C	ISO 11357-3
Flammability	Dry	Conditioned		Test Method
Flame Rating (1.6 mm)	HB	--		UL 94
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.

The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design

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