TECHNYL® A 218 MV30 BLACK

Polyamide 66

Solvay Engineering Plastics

Message:

TECHNYL® A 218 MV30 Black is a polyamide 66, reinforced with 30% of mixed glass fibre and mineral filler, heat stabilized, for injection moulding. This grade offers an excellent combination between thermal and mechanical properties as well as a low warpage of molded parts.

General Information				
Filler / Reinforcement	Glass \mineral, 30% filler by weight			
Additive	heat stabilizer			
Features	Heat Stabilized - Inorganic Low warpage			
Uses	Application in Automobile Field			
RoHS Compliance	RoHS compliance			
Appearance	Black			
Forms	Particle			
Processing Method	Injection molding			
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)			
Resin ID (ISO 1043)	PA66-(GF+MD)30			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.35	--	g/cm³	ISO 1183/A
Water Absorption (Equilibrium, 23°C, 50% RH)	2.1	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus (23°C)	8600	5100	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	138	75.0	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	2.6	7.2	%	ISO 527-2
Flexural Modulus (23°C)	7400	3800	MPa	ISO 178
Flexural Stress (23°C)	205	135	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength (23°C)	20	--	kJ/m²	ISO 179/1eU
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	255	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	240	--	°C	ISO 75-2/Af
Melting Temperature	260	--	°C	ISO 11357-3
Injection	**Dry**	**Unit**		
Drying Temperature	80		°C	

Suggested Max Moisture	0.20	%
Rear Temperature	270 - 280	°C
Middle Temperature	275 - 285	°C
Front Temperature	280 - 290	°C
Mold Temperature	70 - 100	°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

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China