

TECHNYL® C 246 NATURAL

Polyamide 6
Solvay Engineering Plastics

Message:

TECHNYL® C 246 Natural is an unfilled polyamide 6, impact modified , for injection moulding. This grade offers high impact strength, flexibility and good surface aspect.

General Information				
Additive		Impact modifier		
Features		Impact resistance, high		
		Low temperature impact resistance		
		Good demoulding performance		
		Excellent appearance		
Uses		Large household appliances and small household appliances		
		Power/other tools		
		Industrial application		
		Sporting goods		
		Consumer goods application field		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS compliance		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA6		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.06	--	g/cm ³	ISO 1183/A
Water Absorption (23°C, 24 hr)	1.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	1600	500	MPa	ISO 527-2/1A
Tensile Stress (Yield, 23°C)	38.0	34.0	MPa	ISO 527-2/1A
Flexural Modulus (23°C)	1550	400	MPa	ISO 178
Flexural Stress (23°C)	70.0	25.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	15	--	kJ/m ²	ISO 179/1eA
23°C	82	--	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength (23°C)	No Break	--		ISO 179/1eU
Notched Izod Impact (23°C)	80	--	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	60.0	--	°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)	--	18	kV/mm	IEC 60243-1
Relative Permittivity	3.50	4.00		IEC 60250
Dissipation Factor	0.020	0.12		IEC 60250
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	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	235 - 245		°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 2-4h

Injection 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.

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