

# TECHNYL® C 218 MX30 BLACK 21N-K

Polyamide 6

Solvay Engineering Plastics

## Message:

TECHNYL® C 218 MX30 Black 21N-K is a polyamide 6, reinforced 30 % mineral filler, heat stabilized, for injection moulding. This grade offers an excellent combination between dimensional stability and mechanical properties.

General Information				
Filler / Reinforcement	Mineral filler, 30% filler by weight			
Additive	heat stabilizer			
Features	Heat Stabilized - Inorganic Good dimensional stability Low warpage			
Uses	Large household appliances and small household appliances Industrial application Application in Automobile Field Consumer goods application field			
RoHS Compliance	RoHS compliance			
Appearance	Black			
Forms	Particle			
Processing Method	Injection molding			
Resin ID (ISO 1043)	PA6-MD30			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm <sup>3</sup>	ISO 1183/A
Water Absorption (23°C, 24 hr)	1.0	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Stress (Break, 23°C)	83.0	--	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	5.0	--	%	ISO 527-2
Flexural Modulus (23°C)	5500	--	MPa	ISO 178
Flexural Stress (23°C)	125	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C)	2.5	--	kJ/m <sup>2</sup>	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	150	--	°C	ASTM D648
Melting Temperature	222	--	°C	ISO 11357-3
Flammability	Dry	Conditioned		Test Method

Flame Rating (3.2 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.

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#### Recommended distributors for this material

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