

TECHNYL® A 217-1 NATURAL

Polyamide 66
Solvay Engineering Plastics

Message:

TECHNYL® A 217-1 Natural is an unreinforced polyamide 66, heat stabilized, standard viscosity, for injection moulding. This grade offers all the primary properties of unreinforced polyamide 66. In addition it has improved resistance to high temperature and it can be used for components which have to withstand mid term temperature stresses.

General Information				
Additive	heat stabilizer			
Features	Heat Stabilized - Inorganic			
	Good liquidity			
	Good demoulding performance			
Uses	Fasteners			
	Connector			
RoHS Compliance	RoHS compliance			
Appearance	Black			
	Natural color			
Forms	Particle			
Processing Method	Injection molding			
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)			
Resin ID (ISO 1043)	PA66			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
23°C, 24 hr	1.3	--	%	ISO 62
Saturated, 23°C	8.3	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.9	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3200	1400	MPa	ISO 527-2/1A
Tensile Stress				ISO 527-2/1A
Yield, 23°C	85.0	--	MPa	ISO 527-2/1A
Fracture, 23°C	55.0	50.0	MPa	ISO 527-2/1A
Tensile Strain (Yield, 23°C)	> 30	> 300	%	ISO 527-2
Flexural Modulus				
23°C	3300	--	MPa	ASTM D790
23°C	2900	--	MPa	ISO 178

Flexural Strength				
23°C	115	--	MPa	ASTM D790
23°C	120	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.5	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, not annealed	233	--	°C	ASTM D648
0.45 MPa, not annealed	200	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	75.0	--	°C	ASTM D648, ISO 75-2/Af
Melting Temperature	262	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	265 - 275		°C	
Middle Temperature	270 - 280		°C	
Front Temperature	280 - 285		°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.

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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