

Vydyne® 21X1

Polyamide 66

Ascend Performance Materials Operations LLC

Message:

Vydyne 21X1 is a general-purpose PA66 resin. Available in natural, it is designed principally for injection-molding applications with the added benefit of improved flow during the molding process. 21X1 offers the same well-balanced combination of engineering properties characterized by high strength; rigidity; good toughness; high melt point; good surface lubricity; abrasion resistance and resistance to many chemicals, machine and motor oils, solvents and gasoline.

Vydyne 21X1 resin permits production of molded parts with good initial color plus good property and color retention when using regrind. This resin is recognized by Underwriters Laboratories and conforms to the requirements of many industrial, federal, and military specifications for premium-quality, general-purpose PA66 resins.

Vydyne 21X1 is externally lubricated and intended for use in high-productivity applications. In many applications, the molding cycle can be reduced because parts may be removed from the cavity at higher temperatures. In difficult molds where parts have a tendency to stick in the cavity, Vydyne 21X1 can reduce or eliminate the need for mold release sprays. Critical molded part dimensions should be checked against specifications before implementing shorter molding cycles on a routine production basis.

Typical Applications/End Uses:

Vydyne 21X1 resin has been used in many molding applications such as terminal blocks, bearings, bushings, cams, electrical connectors and housings, electrical cable ties/tie straps and many other hardware and general industrial parts.

General Information	
Additive	Lubricant
Features	Fast Molding Cycle
	Gasoline Resistance
	Good Abrasion Resistance
	Good Chemical Resistance
	Good Mold Release
	Good Toughness
	High Rigidity
	High Strength
	Lubricated
	Oil Resistant
	Solvent Resistant
Uses	Bearings
	Bushings
	Cams
	Connectors
	Electrical Housing
	Industrial Applications
Agency Ratings	ASTM D 4066 PA0111
	ASTM D 6779 PA0111
	FDA 21 CFR 177.1500
	FED L-P-410A

RoHS Compliance		RoHS Compliant		
UL File Number		E70062		
Appearance		Natural Color		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	2.0	--	%	
Flow : 23°C, 2.00 mm	2.0	--	%	
Water Absorption				ISO 62
23°C, 24 hr	1.2	--	%	
Equilibrium, 23°C, 50% RH	2.4	--	%	
Outdoor Suitability	f2	--		UL 746C
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3300	1600	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield, 23°C	88.0	55.0	MPa	
Break, 23°C	60.0	45.0	MPa	
Tensile Strain (Yield, 23°C)	5.0	20	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	20	> 50	%	ISO 527-2
Flexural Modulus (23°C)	3300	1050	MPa	ISO 178
Flexural Strength (23°C)	105	30.0	MPa	ISO 178
Poisson's Ratio	0.40	--		ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	5.0	7.0	kJ/m ²	
23°C	6.0	23	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	No Break		
23°C	No Break	No Break		
Notched Izod Impact Strength				ISO 180
-30°C	5.0	7.0	kJ/m ²	
23°C	6.0	23	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, Unannealed	210	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	72.0	--	°C	ISO 75-2/A
Melting Temperature	260	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	1.0E-4	--	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	1.0E-4	--	cm/cm/°C	
RTI Elec				UL 746
0.710 mm	130	--	°C	
1.50 mm	130	--	°C	
3.00 mm	130	--	°C	
RTI Imp				UL 746
0.710 mm	75.0	--	°C	
1.50 mm	75.0	--	°C	
3.00 mm	75.0	--	°C	
RTI Str				UL 746
0.710 mm	85.0	--	°C	
1.50 mm	85.0	--	°C	
3.00 mm	85.0	--	°C	
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity (0.750 mm)	1.0E+13	--	ohms · cm	IEC 60093
Dielectric Strength (1.00 mm)	26	--	kV/mm	IEC 60243
Arc Resistance (3.00 mm)	PLC 5	--		ASTM D495
Comparative Tracking Index (3.00 mm)	600	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.710 mm	PLC 0	--		
1.50 mm	PLC 0	--		
3.00 mm	PLC 0	--		
High Voltage Arc Tracking Rate (HVTR)	PLC 0	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.710 mm	PLC 4	--		
1.50 mm	PLC 3	--		
3.00 mm	PLC 2	--		
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.710 mm	V-2	--		
1.50 mm	V-2	--		

3.00 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.710 mm	960	--	°C	
1.50 mm	960	--	°C	
3.00 mm	960	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.710 mm	850	--	°C	
1.50 mm	850	--	°C	
3.00 mm	850	--	°C	
Oxygen Index	26	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	< 70.0		°C	
Drying Time	1.0 to 3.0		hr	
Suggested Max Regrind	50		%	
Rear Temperature	260 to 280		°C	
Middle Temperature	270 to 285		°C	
Front Temperature	280 to 290		°C	
Nozzle Temperature	280 to 300		°C	
Processing (Melt) Temp	285 to 300		°C	
Mold Temperature	65.0 to 95.0		°C	

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