

TECHNICAL DATA SHEET

TECHNYL A 20 V25 NATURAL

TECHNYL® A 20 V25 Natural is a Red Phosphorous flame retardant polyamide 66, reinforced with 25% of glass fiber, heat stabilized, for injection moulding. This grade provides robust UL 94 V-0 and a full UL yellow card while offering good mechanical properties. This grade is suitable for moulding insulating parts for electrical devices, and more generally for thin parts under stress.

General

Feature	halogen free flame retardant	
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Certification	RoHS EC 1907/2006 (REACH)	UL listed product
Applications	Appliances Electrical/Electronic Applications Valves/Valve Parts	Connectors Pump Parts White Goods & Small Appliances
Colors available	Black	Natural
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66-GF25 FR(52)
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Condition	Standard	Unit	Value
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Physical properties

		Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.38
Water absorption	24 hr, 23°C	ISO 62	%	0.75
Molding shrinkage, parallel	72 hr, 23°C, 50% RH	ISO 294-4, 2577	%	0.35
Molding shrinkage, normal	72 hr, 23°C, 50% RH	ISO 294-4, 2577	%	1.2

Mechanical properties

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		Standard	Unit	Value
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9400 / 6300
Stress at break		ISO 527-1/-2	MPa	150 / 100
Strain at break		ISO 527-1/-2	%	2.5 / 5.2
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8500 / 5700
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	255 / 170
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	55 / 60
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	50 / -

	Condition	Standard	Unit	Value
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	8 / 9
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	7 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	8 / 9

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	244

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+013
Comparative tracking index	Solution A	IEC 60112	V	400
Dielectric strength	1 mm	IEC 60243-1	kV/mm	30

Burning behaviour

UL Yellow Card availability				<u>QMFZ2.E44716</u>
Flammability, 0.75 mm	0.75 mm	UL 94		V0
Flammability, 1.5 mm	1.5 mm	UL 94		V0
Flammability, 3.0 mm	3.0 mm	UL 94		V0
Glow-wire flammability index, GWFI, 0.75 mm	0.75 mm	IEC 60695-2-12	°C	960
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	960
Glow-wire flammability index, GWFI, 3.0 mm	3.0 mm	IEC 60695-2-12	°C	960
Glow-wire ignition temperature, GWIT, 1.5 mm	1.5 mm	IEC 60695-2-13	°C	725
Oxygen index			%	31

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	265 - 275 °C
Middle temperature	270 - 280 °C
Front temperature	280 - 290 °C
Recommended mould temperature	60 - 90 °C

Injection notes

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

All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, Domo recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, Domo advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% Chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design

Disclaimer

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