TECHNYL®

TECHNYL® A 205F NATURAL

TECHNICAL DATA SHEET

Revised: September, 2018

TECHNYL® A 205F Natural is an unreinforced polyamide 66 for injection moulding. This grade offers two main advantages: excellent filling qualities and UL 94 V2 under 0.4 mm. It is particularly suitable for the moulding of long parts with thin wall sections

GENERAL

Material Status	• Commercial: Active	
Availability	• Africa & Middle East • Asia Pacific • Europe	• Latin America • North America
Key Benefits	• Fast Molding Cycle • Good Flow	• Good Mold Release • UL 94 V2 at 0.4 mm
Applications	• Cable ties • Clips & Fasteners • Connectors • Consumer and Industrial applications	• Electrical/Electronic Applications • Fixation systems • Furnitures • Switch, Plug, Control & Sockets
Certification/Compliance	• EC 1907/2006 (REACH) • EN 45545	• UL QMFZ2
RoHS Compliance	• RoHS Compliant	
Automotive Specifications	• FORD WSK-M4D647-A • GM QK 002911 Color: Natural	• IMDS ID 4606347 Color: Natural • IMDS ID 4606347/2
Colors Available	• Black • Grey	• Natural Color • White
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66	

PROPERTIES

Typical values of properties are for Natural grades

Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 294-4
Across Flow	1.7		%	
Flow	1.7		%	
Water Absorption				
24 hr, 23°C	1.3		%	ISO 62
Equilibrium, 23°C, 50% RH	3.0		%	ISO 1110
Density	1.14		g/cm³	ISO 1183/A

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3200	1400	MPa	ISO 527-2/1A

Solvay Engineering Plastics
www.solvay.com - www.technyl.com

Tel: 00 800 55 400 600
technyl-emea@solvay.com - Europe, Middle East, Africa
technyl-apac@solvay.com - Asia Pacific
technyl-americas@solvay.com - Americas

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Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength				
Yield, 23°C	85		MPa	ASTM D638
Yield, 23°C	85	50	MPa	ISO 527-2/1A
Break, 23°C	60	40	MPa	ISO 527-2/1A
Tensile Strain				
Yield, 23°C	4.0	10	%	ISO 527-2
Break, 23°C	25		%	ASTM D638
Break, 23°C	50	250	%	ISO 527-2
Flexural Modulus				
23°C	3350		MPa	ASTM D790
23°C	3000	1300	MPa	ISO 178
Flexural Strength				
23°C	125		MPa	ASTM D790
23°C	120	50.0	MPa	ISO 178
Charpy Notched Impact Strength (23°C)	5.0	10	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Notched Izod Impact				
23°C	80		J/m	ASTM D256
23°C	5.0	8.0	kJ/m²	ISO 180

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	205		°C	ISO 75-2/Bf
1.8 MPa, Unannealed	80		°C	ASTM D648
1.8 MPa, Unannealed	65		°C	ISO 75-2/Af
Melting Temperature	263		°C	ISO 11357-3

Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	5.0E+15	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+15	ohms·cm	IEC 60093
Electric Strength				IEC 60243-1
23°C, 0.800 mm	35		kV/mm	
23°C, 2.00 mm	22		kV/mm	
Relative Permittivity (23°C, 2.00 mm, 1 MHz)	3.50			IEC 60250
Dissipation Factor (1 MHz)	0.033			IEC 60250
Comparative Tracking Index				IEC 60112
Solution A	600	600	V	
Solution B	550		V	

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Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.40 mm	V-2			
0.8 mm	V-2			
1.6 mm	V-2			
3.2 mm	V-2			
Glow Wire Flammability Index (1.6 mm)	800		°C	IEC 60695-2-12
Oxygen Index	28		%	ISO 4589-2

Additional Information	Dry	Unit	Test Method
European Railways Certifications			
R22	HL2		GE
R23	HL2		EN 45545-2

PROCESSING

Injection	Dry	Unit
Drying Temperature	80	°C
Suggested Max Moisture	0.20	%
Rear Temperature	265 to 275	°C
Middle Temperature	270 to 280	°C
Front Temperature	280 to 285	°C
Mold Temperature	60 to 80	°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:

- For unfilled polyamides, Solvay recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm). 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

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and it is in no way binding. This information must on no account be used as a substitutive for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANDABILITY OR FITNESS FOR A PARTICULAR PURPOSE IS EXPRESSLY EXCLUDED. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document, and Solvay is at their disposal to supply any additional information.

SAFETY INFORMATION

Detailed information regarding safety are available on the safety data sheet (SDS). SDS is sent with the first material order or available by contacting our customer services

REGULATIONS COMPLIANCE

This product is not intended to be used for the following regulated market: food contact, drinking water, toys, cosmetics or medical devices.

This grade complies with ROHS Directive 2011/65/EU and 2015/863 as amended.

Grades produced or imported in Europe comply with REACH directive 1907/2006/EC as amended.

CUSTOMER SERVICES

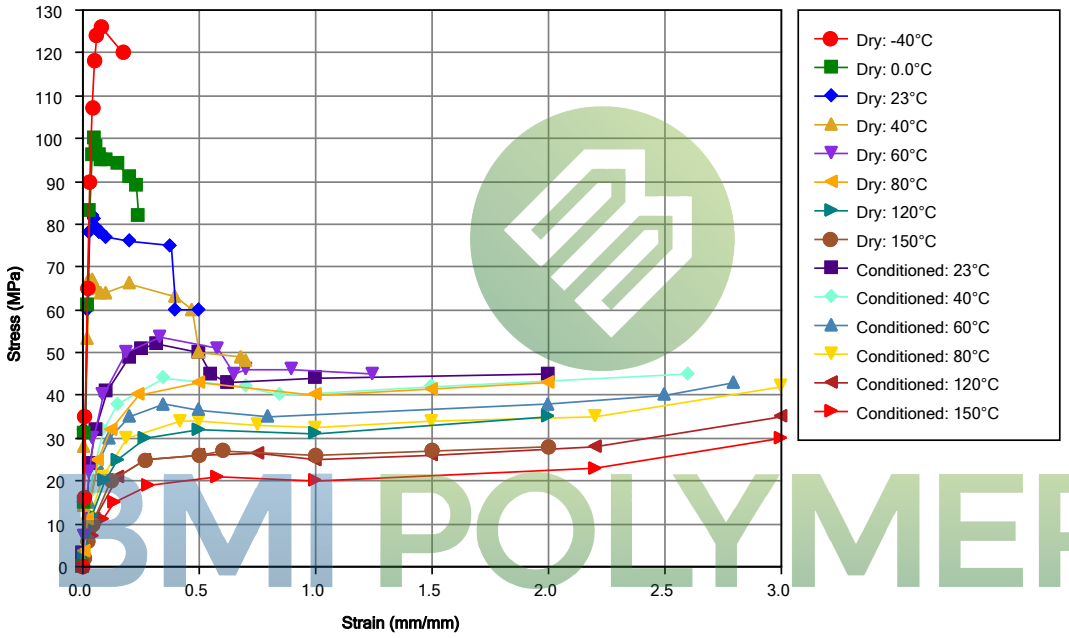
Our customer services are not only concerned with manufacturing and supply of Engineering Plastics products. We are available to assist our customers in finding technical solutions that meet their requirements. Specific support is in particular offered on:

- Material selection
- Material testing
- Parts design advice, training for design engineers
- Part testing
- Design simulation
- Processing through different technologies
- Assembly and post-processing technology expertise
- Parts optimization through Computer Aided Design

You can find more information on Solvay Product range on our internet product finder at the following address: http://www.technyl.com

MULTIPOINT DATA

Isothermal Stress vs. Strain (ISO 11403-1)



Notes

Typical properties: these are not to be construed as specifications.

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