TECHNYL®

TECHNYL® A 246M NATURAL

TECHNICAL DATA SHEET

Revised: September, 2018

TECHNYL® A 246M Natural is an unfilled polyamide 6.6, impact modified, for injection moulding. This grade offers an excellent impact resistance, even at low temperature.

GENERAL

Material Status	• Commercial: Active	
Availability	• Africa & Middle East • Asia Pacific • Europe	• Latin America • North America
Additive	• Impact Modifier	
Key Benefits	• High Impact Resistance • Low Temperature Impact Resistance	• Good Mold Release
Applications	• Automotive applications • Consumer and Industrial applications • Outdoors activities • Power tool housings	• Power tools • Shoe soles • Ski bindings • Sports equipment
Certification/Compliance	• EC 1907/2006 (REACH)	• UL QMFZ2
RoHS Compliance	• RoHS Compliant	
Colors Available	• Black	• Natural Color
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	1.6		%	
Flow	1.6		%	
Water Absorption (24 hr, 23°C)	1.1		%	ISO 62
Density	1.08		g/cm³	ISO 1183/A

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	1900	600	MPa	ISO 527-2/1A
Tensile Strength				
Yield, 23°C	50		MPa	ASTM D638
Yield, 23°C	47	42	MPa	ISO 527-2/1A
Break, 23°C	44	35	MPa	ISO 527-2/1A
Tensile Strain				
Yield, 23°C	20	210	%	ISO 527-2
Break, 23°C	80		%	ASTM D638

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Mechanical	Dry	Conditioned	Unit	Test Method
Flexural Modulus				
23°C	1800		MPa	ASTM D790
23°C	1800	700	MPa	ISO 178
Flexural Strength				
23°C	70.0		MPa	ASTM D790
23°C	70.0	27.0	MPa	ISO 178
Charpy Notched Impact Strength (23°C)	97	100	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	16		kJ/m²	
23°C	No Break			
Notched Izod Impact				
23°C	100	120	J/m	ASTM D256
-30°C	22		kJ/m²	ISO 180
23°C	60	80	kJ/m²	ISO 180

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	200		°C	ASTM D648
1.8 MPa, Unannealed	63		°C	ASTM D648
1.8 MPa, Unannealed	65		°C	ISO 75-2/Af
Melting Temperature	263		°C	ISO 11357-3 ASTM D3417

Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+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)	0.020			IEC 60250
Comparative Tracking Index				IEC 60112
Solution A	575	600	V	
Solution B	450		V	

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB			UL 94

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

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

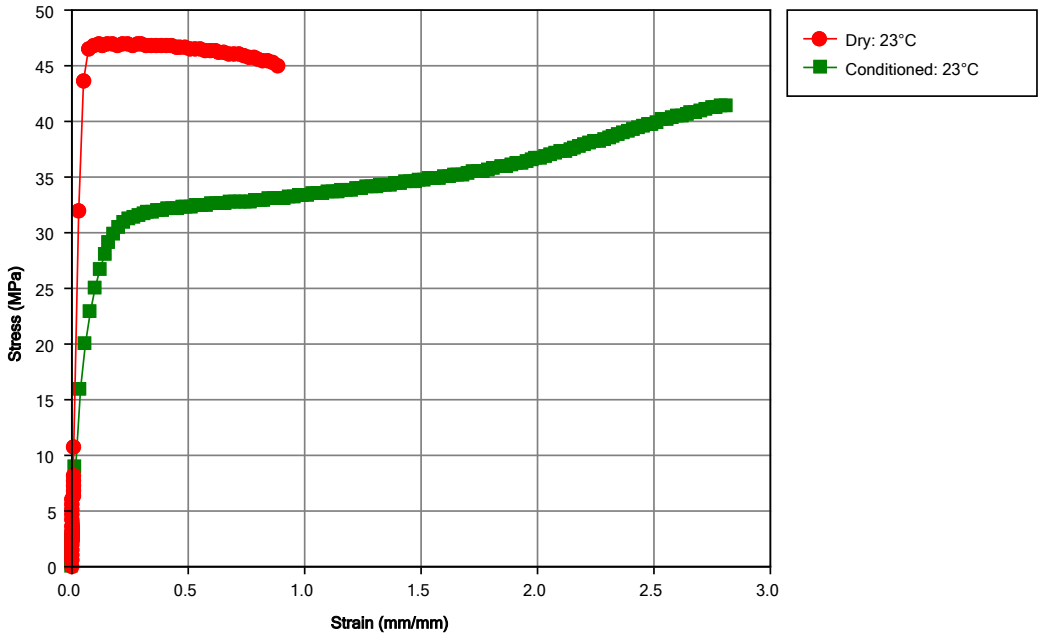
Our customer services are not only concerned with manufacturing and supply of Engineering Plastics products. We are available to assist our customers in finding technical solutions that meet their requirements. Specific support is in particular offered on:

- 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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