

TECHNICAL DATA SHEET

**TECHNYL STAR S 52G1 MX25 GY 2408**

TECHNYL STAR S 52G1 MX25 GY 2408 is a grade based on a non-phosphorous and non-halogenated flame retardant system and on a patented high flow polyamide 6 resin (TechnylStar), reinforced of 25% of mineral filler, for injection moulding. This grade offers a high fluidity as well as a robust glow wire resistance.

**General**

Feature	Arc resistant Excellent surface finish	Very high flow halogen free flame retardant
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Electrical/Electronic Applications	
Colors available	Black Grey	Natural
Forms	Pellets	

**Product identification**

ISO 1043 abbreviation	PA6-MD25 FR(30)
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Condition	Standard	Unit	Value
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**Physical properties**

	Condition	Standard	Unit	Value
Water absorption	24 hr, 23°C	ISO 62	%	1.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.6
Molding shrinkage, normal		ISO 294-4, 2577	%	0.7

**Mechanical properties**

dam / cond.\*

	Condition	Standard	Unit	Value
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6800 / 4500
Stress at break		ISO 527-1/-2	MPa	70 / 55
Strain at break		ISO 527-1/-2	%	2 / 4
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	30 / 50
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	3 / 6
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	28 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	3.5 / -

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	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	220
<b>Electrical properties</b>				
Comparative tracking index	Solution A	IEC 60112	V	600
CTI performance level category		Sol A		PLC 0
<b>Burning behaviour</b>				
Flammability, 0.75 mm	0.75 mm	UL 94		V2
Flammability, 1.5 mm	1.5 mm	UL 94		V2
Flammability, 3.0 mm	3.0 mm	UL 94		V0
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, 0.75 mm	0.75 mm	IEC 60695-2-13	°C	725
Glow-wire ignition temperature, GWIT, 1.5 mm	1.5 mm	IEC 60695-2-13	°C	960
Oxygen index			%	29

\*: conditioned according to ISO 1110

**Processing conditions**

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	240 - 245 °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 minimum -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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