

TECHNICAL DATA SHEET

**TECHNYL STAR SX 218 V60 NC**

TECHNYL STAR SX 218 V60 NC is based on a patented high flow polyamide 6 resin (Technylstar), heat stabilized, reinforced with 60% of glass fibre, for injection moulding. Due to its outstanding flow characteristics, this grade allows more freedom in mould and part design versus a standard polyamide solutions.

**General**

Feature	Heat-aging stabilized Very high flow High stiffness	High dimensional stability Excellent surface finish
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Automotive Applications Outdoor Applications Sport	Handles Pulleys
Colors available	Black	Natural
Forms	Pellets	

**Product identification**

ISO 1043 abbreviation	PA6-GF60
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Condition	Standard	Unit	Value
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**Physical properties**

Density		ISO 1183	g/cm <sup>3</sup>	1.65
Water absorption	24 hr, 23°C	ISO 62	%	0.55

**Mechanical properties**

dam / cond.\*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	21000 / 15500
Stress at break		ISO 527-1/-2	MPa	240 / 165
Strain at break		ISO 527-1/-2	%	2.4 / 3.4
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	19500 / 14000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	380 / 280
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	90 / 95
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	16 / 20
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m <sup>2</sup>	90 / 100
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	18 / 22

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	222
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	215

### Burning behaviour

Flammability, 1.5 mm	1.5 mm	UL 94		HB
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\*: 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 - 245 °C
Front temperature	245 - 250 °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

For reinforced polyamides, Domo recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 /1.2379 (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

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