

TECHNYL® A 218W V33 Natural T is a polyamide 66, reinforced with 30% of glass fibre, heat stabilized, for injection moulding. The product is particularly recommended for the moulding of parts where some translucency is required, as well as surface aesthetics is important.

GENERAL

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer
Key Benefits	• Good Dimensional Stability • Good Flow • Low Halogen Content • Heat Stabilized (Organic) • Good Mold Release
Applications	• Bobbins Coil • Connectors • Suspension components
RoHS Compliance	• RoHS Compliant
Automotive Specifications	• FORD WSA-M4D768-A
Colors Available	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA66-GF33

PROPERTIES

Typical values of properties are for Natural grades

Physical	Dry Unit	Test Method
Density	1.40 g/cm ³	ISO 1183/A

Mechanical	Dry Unit	Test Method
Tensile Modulus (23°C)	10200 MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	190 MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	3.8 %	ISO 527-2
Flexural Modulus (23°C)	8950 MPa	ISO 178
Flexural Stress (23°C)	294 MPa	ISO 178
Charpy Notched Impact Strength (23°C)	11 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	91 kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	11 kJ/m ²	ISO 180

Thermal	Dry Unit	Test Method
Heat Deflection Temperature		
0.45 MPa, Unannealed	263 °C	ISO 75-2/Bf
1.8 MPa, Unannealed	247 °C	ISO 75-2/Af
Melting Temperature	263 °C	ISO 11357-3

PROCESSING

Injection	Dry Unit
Drying Temperature	80 °C
Suggested Max Moisture	0.20 %
Rear Temperature	270 to 280 °C
Middle Temperature	275 to 285 °C
Front Temperature	280 to 290 °C
Mold Temperature	70 to 100 °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 reinforced polyamides, Solvay 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

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.

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

Notes

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