

TECHNYL® C 218 MZ20 V10 Black Z is a polyamide 6, reinforced 20 % mineral filler and 10 % of glass fibre, heat stabilized, for injection moulding. This grade offers an excellent planarity of the end product, good mechanical properties and a high dimensional stability.

GENERAL

Material Status	• Commercial: Active	
Availability	• Asia Pacific	
Filler / Reinforcement	• Glass\Mineral, 30% Filler by Weight	
Additive	• Heat Stabilizer	
Key Benefits	• Heat Stabilized (Inorganic) • Good Mold Release	• Low Warpage
Applications	• Automotive applications	• Engine covers
RoHS Compliance	• RoHS Compliant	
Colors Available	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6-MD20+GF10	

PROPERTIES

Typical values of properties are for Black grades

Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 294-4
Across Flow	0.80		%	
Flow	0.15		%	
Water Absorption				ISO 62
Saturation, 23°C	6.0		%	
Equilibrium, 23°C, 50% RH	2.2		%	
Density	1.36		g/cm³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	7000	4000	MPa	ISO 527-2/1A
Tensile Strength				
Break, 23°C	110		MPa	ASTM D638
Break, 23°C	90	45	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	2.0	3.0	%	ISO 527-2
Flexural Modulus				
23°C	6500		MPa	ASTM D790
23°C	9300		MPa	ISO 178

Mechanical	Dry	Conditioned	Unit	Test Method
Flexural Strength				
23°C	175		MPa	ASTM D790
23°C	255		MPa	ISO 178
Charpy Notched Impact Strength (23°C)	14	10	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	85	kJ/m²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	15		kJ/m²	ISO 180
Unnotched Izod Impact Strength (23°C)	80		kJ/m²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				ISO 75-2/Af
1.8 MPa, Unannealed	205		°C	
Melting Temperature	222		°C	ISO 11357-3

PROCESSING

Injection	Dry	Unit
Drying Temperature	80	°C
Suggested Max Moisture	0.20	%
Rear Temperature	230 to 235	°C
Middle Temperature	235 to 240	°C
Front Temperature	240 to 250	°C
Mold Temperature	60 to 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 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.