

TECHNYL STAR® AFX 60G1 V45 GREY 2633

TECHNICAL DATA SHEET

Revised: December, 2018

TECHNYL STAR® AFX 60G1 V45 Grey 2633 is a high flow polyamide 66 based on a non-halogenated flame retardant system, reinforced of 45% of glass fiber, heat stabilized, for injection moulding. This grade offers excellent electrical properties combined with flame retardancy performance

GENERAL

Material Status	• Commercial: Active	
Availability	• Africa & Middle East	• Europe
Filler / Reinforcement	• Glass Fiber, 45% Filler by Weight	
Additive	• Flame Retardant	• Heat Stabilizer
Key Benefits	• High Flow • Good Mold Release • High Stiffness	• Superior Surface Finish • UL 94 V0 at 0.8 mm
Applications	• Electrical protection devices	• Electrical/Electronic Applications
Certification/Compliance	• EC 1907/2006 (REACH) • EN 45545	• UL QMFZ2
Colors Available	• Blue	• Grey
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66-GF45 FR(40)	

PROPERTIES

Typical values of properties are for Grey grades

Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 294-4
Across Flow	0.65		%	
Flow	0.35		%	
Water Absorption (24 hr, 23°C)	0.60		%	ISO 62
Density	1.57		g/cm³	ISO 1183/A

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	17300	12000	MPa	ISO 527-2/1A
Tensile Stress (Break, 23°C)	180	130	MPa	ISO 527-2/1A
Tensile Strain (Break, 23°C)	2.0	3.1	%	ISO 527-2
Flexural Modulus (23°C)	13400	10900	MPa	ISO 178
Flexural Stress (23°C)	290	210	MPa	ISO 178
Charpy Notched Impact Strength (23°C)	9.7	11	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	64	59	kJ/m²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	8.0	10	kJ/m²	ISO 180
Unnotched Izod Impact Strength (23°C)	53	53	kJ/m²	ISO 180/1U

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature 1.8 MPa, Unannealed	250		°C	ISO 75-2/Af
Melting Temperature	263		°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	6.7E+15		ohms	IEC 60093
Volume Resistivity	1.1E+15		ohms·cm	IEC 60093
Electric Strength (2.00 mm)	44		kV/mm	IEC 60243-1
Comparative Tracking Index (Solution A)	600		V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.8 mm	V-0			
1.6 mm	V-0			
3.2 mm	V-0			
Glow Wire Flammability Index				IEC
0.8 mm	960		°C	60695-2-12
1.6 mm	960		°C	
Oxygen Index	34		%	ISO 4589-2

PROCESSING

Injection	Dry	Unit
Drying Temperature	80	°C
Suggested Max Moisture	0.20	%
Rear Temperature	260 to 270	°C
Middle Temperature	265 to 275	°C
Front Temperature	265 to 280	°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:

- 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, Solvay recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, Solvay 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

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, MERCHANTABILITY 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.

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

MULTIPOINT DATA

Isothermal Stress vs. Strain (ISO 11403-1)

