

TECHNYL STAR® S 60G1 V30 GREY R7035 CF

TECHNICAL DATA SHEET

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TECHNYL STAR® S 60G1 V30 Grey R7035 CF is a grade based on a non-halogenated flame retardant system and on a patented high flow polyamide 6 resin (TechnylStar), reinforced of 30% of glass fiber, heat stabilized, for injection moulding. This grade is Heat stabilized and provides optimized injection moulding performance.

GENERAL

Material Status	• Commercial: Discontinued	
Availability	• Africa & Middle East • Asia Pacific	• Europe
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Additive	• Flame Retardant	• Heat Stabilizer
Key Benefits	• High Arc Resistance • Lower Corrosivity • High Flow • Low Temperature Impact Resistance	• Good Mold Release • Superior Surface Finish • UL 94 V0 at 0.4 mm
Applications	• Circuit Breaker • Connectors • Conversion Devices • Electrical protection devices	• Electrical/Electronic Applications • Junction box • Smart devices
Certification/Compliance	• EC 1907/2006 (REACH) • EN 45545	• UL QMFZ2
Colors Available	• Black • Grey	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6-GF30 FR(40)	

PROPERTIES

Typical values of properties are for Grey grades

Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 294-4
Across Flow	0.90		%	
Flow	0.25		%	
Water Absorption				ISO 62
24 hr, 23°C	0.90		%	
Saturation, 23°C	4.1		%	
Equilibrium, 23°C, 50% RH	1.7		%	
Density	1.42		g/cm³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10000	6400	MPa	ISO 527-2/1A

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength				
Break, 23°C	109		MPa	ASTM D638
Break, 23°C	110	70	MPa	ISO 527-2/1A
Tensile Elongation				
Break, 23°C	2.1		%	ASTM D638
Break, 23°C	1.9	3.5	%	ISO 527-2
Flexural Modulus				
23°C	9670		MPa	ASTM D790
23°C	9000	5000	MPa	ISO 178
Flexural Strength				
23°C	160		MPa	ASTM D790
23°C	170	120	MPa	ISO 178
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	5.0		kJ/m ²	
23°C	5.0	6.5	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	25		kJ/m ²	
23°C	32	35	kJ/m ²	
Notched Izod Impact				
23°C	57		J/m	ASTM D256
23°C	5.0	6.0	kJ/m ²	ISO 180
Unnotched Izod Impact Strength (23°C)	27	32	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	205		°C	ASTM D648
1.8 MPa, Unannealed	205		°C	ISO 75-2/ Af
Melting Temperature	222		°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	6.0E+14		ohms	IEC 60093
Volume Resistivity	1.0E+15		ohms·cm	IEC 60093
Electric Strength				IEC 60243-1
0.800 mm	38		kV/mm	
2.00 mm	25	23	kV/mm	
Relative Permittivity	2.90	4.35		IEC 60250
Dissipation Factor		0.080		IEC 60250
Comparative Tracking Index (Solution A)	600	600	V	IEC 60112

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.40 mm	V-0			
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	
3.2 mm	960		°C	
Glow Wire Ignition Temperature				IEC
0.8 mm	775		°C	60695-2-13
1.6 mm	800		°C	
3.2 mm	825		°C	
Oxygen Index	35		%	ISO 4589-2
Additional Information				Test Method
European Railways Certifications			Dry Unit	EN 45545-2
R22			HL2	
R23			HL3	

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 245 °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)

