


Technyl® eXten D 437P






PA610

Solvay Engineering Plastics

Product Texts
High viscosity unfilled polyamide (PA6, 10) for extrusion applications

Rheological properties		dry / cond	Unit	Test Standard
ISO Data				
Molding shrinkage, parallel		2.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal		2.3 / *	%	ISO 294-4, 2577
Mechanical properties		dry / cond	Unit	Test Standard
ISO Data				
Tensile Modulus		890 / 830	MPa	ISO 527-1/-2
Stress at 50% strain		50 / 41	MPa	ISO 527-1/-2
Strain at break		>50 / >50	%	ISO 527-1/-2
Charpy impact strength (+23°C)		N / N	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C		N / N	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)		25 / 55	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C		4 / 3.5	kJ/m²	ISO 179/1eA
Thermal properties		dry / cond	Unit	Test Standard
ISO Data				
Melting temperature (10°C/min)		215 / *	°C	ISO 11357-1/-3
Thickness tested		1.6 / *	mm	IEC 60695-11-10
UL recognition		UL / *	-	-
Burning behav. at thickness h		HB / *	class	IEC 60695-11-10
Other properties		dry / cond	Unit	Test Standard
ISO Data				
Water absorption		3.1 / *	%	Sim. to ISO 62
Humidity absorption		0.5 / *	%	Sim. to ISO 62
Density		1050 / -	kg/m³	ISO 1183
Other text information				
Injection Molding				
<small>The material is supplied in airtight bags, ready for use. In the case that the virgin material has absorbed</small>				
moisture, it must be dried to a final moisture content less than 0,1% with a dehumidified air drying equipment at approximately 80°C.				
Extrusion conditions				
Feed zone °C 205-215				
Compression zone °C 215-225				
Front zone °C 215-225				
Die temperatures °C 220-230				
Chemical Media Resistance				
Acids				
☺	Acetic Acid (5% by mass) (23°C)			
☹	Sulfuric Acid (38% by mass) (23°C)			
☹	Sulfuric Acid (5% by mass) (23°C)			
Alcohols				
☺	Ethanol (23°C)			

Hydrocarbons Toluene (23°C)**Ketones** Acetone (23°C)**Mineral oils** SAE 10W40 multigrade motor oil (23°C)**Standard Fuels** Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23°C)**Salt solutions** Zinc Chloride solution (50% by mass) (23°C)**Other**

-  Hydrogen peroxide (23°C)
-  Ethylene Glycol (50% by mass) in water (108°C)
-  50% Oleic acid + 50% Olive Oil (23°C)
-  Deionized water (90°C)
-  Phenol solution (5% by mass) (23°C)