

TECHNICAL DATA SHEET

TECHNYL 4EARTH AC2E 216 WT 1126 H
ECONAMID FL 66/6 WT91126



Recycled polyamide 66/6, for injection moulding

General

Polymer type	PA66/6 copolymer
Certifications	RoHS
Feature	recycled
Processing technology	injection moulding

Product identification

ISO 1043 abbreviation	PA66/6(REC)
ISO 16396 designation	PA66/6,(R100),M,S14-030

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.14
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Condition	Standard	Unit	Value
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Mechanical properties

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Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2900 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	45 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	70 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2400 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5 / -
Rockwell hardness		ISO 2039/2	ScaleR	118 / -

*: **conditioned according to ISO 1110**

Condition	Standard	Unit	Value
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Thermal properties

Condition	Standard	Unit	Value
Melting temperature, 10°C/min	ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	ISO 75	°C	195
Temp. of deflection under load, 1.80 MPa	ISO 75	°C	80
Vicat softening temperature	ISO 306	°C	235

Condition	Standard	Unit	Value
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Burning behaviour

Condition	Standard	Unit	Value
Flammability, 0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm	FMVSS 302		< 100 mm/min

Condition	Standard	Unit	Value
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Electrical properties

Condition	Standard	Unit	Value
Volume resistivity	IEC 62631-3-1	ohm.m	1.0E13
Surface resistivity	IEC 62631-3-1	ohm	1.0E13

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	265 - 285 °C
Recommended mould temperature	70 - 120 °C

processing conditions

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

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 minimum -20°C.,Recommended time 2-4h.

Injection advice

For unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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.