TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

OROMID RC66 GF30 BK

OROMID RC66 GF30 BK is a second choice Polyamide 66, reinforced with 30% of glass fiber, for injection moulding.

General

Polymer type	PA66	
Certifications	RoHS	EC 1907/2006 (REACH)
Feature	heat-aging stabilized	second choice
Applications	automotive applications	
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66-GF30
ISO 16396 designation	PA66,GF30,MH,S14-100

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cmÂ³	1.36
Humidity absorption	T=23Â°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23Â°C	ISO 62	%	0.8
Water absorption, saturation			%	5.3

TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

OROMID RC66 GF30 BK

	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7500 / 5000
Stress at break		ISO 527-1/-2	MPa	120 / 90
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7000 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	200 / -

: conditioned according to ISO 1110

	Condition	Standard	Unit	Value
Thermal properties				
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	210

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

Processing conditions

Drying temperature/time	80 Â°C
Suggested max moisture	0.2 %
Rear temperature	280 °C
Middle temperature	285 °C
Front temperature	290 °C
Recommended mould temperature	100 °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 minimum -20Â°C.,Recommended time 2-4h.

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.

DOMO Engineering Plastics

Injection advice

For reinforced polyamides, Domo 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 120Â°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.