

TECHNICAL DATA SHEET

DOMONYL 2152R33H BK-1

DOMONYL 2152R33H BK-1 is a polyamide 66, reinforced with 33% of glass fibre, heat stabilized, for injection moulding. For America availability only.

General

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

Product identification

ISO 1043 abbreviation	PA66-GF33
ISO 16396 designation	PA66,GF33,MH,S14-100

Condition	Standard	Unit	Value
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Physical properties

	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.41
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal	ISO 294-4, 2577	%	0.7 - 0.9

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	12000 / 7100
Stress at break		ISO 527-1/-2	MPa	210 / 130
Strain at break		ISO 527-1/-2	%	2.9 / 5.1
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	10000 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	300 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	74 / 87
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	11 / 15

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	260
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	260

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %

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 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 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 provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all