

TECHNICAL DATA SHEET

TECHNYL 4EARTH A5E 216M GY 7499



Recycled polyamide 66, improved impact resistance, for injection molding, grey

General

Polymer type	PA66
Certifications	RoHS
Feature	impact modified not heat stabilized recycled
Processing technology	injection moulding

Product identification

ISO 1043 abbreviation	PA66-I(REC)
ISO 16396 designation	PA66,(R>50),MP,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	2750 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	75 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	6 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	6 / -

*: **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, 1.80 MPa	1.80 MPa ISO 75	°C	65
Vicat softening temperature	50°C/h - 50N ISO 306	°C	225

Condition	Standard	Unit	Value
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Burning behaviour

Condition	Standard	Unit	Value
Flammability, 0.75 mm	0.75 mm UL 94		HB
Glow-wire flammability index, GWFI, 0.75 mm	0.75 mm IEC 60695-2-12	°C	650
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm IEC 60695-2-12	°C	650
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	270 - 290 °C
Recommended mould temperature	40 - 80 °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 -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.