TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH A5E 236 V30 BK H

ECONAMID FL 66G30 503

Recycled polyamide 66, 30% glass fiber reinforced, impact modified, for injection moulding, black

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA66	
Feature	impact modified	recycled
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66-I(REC)-GF30
ISO 16396 designation	PA66,GF30(R100),PM,S14-070

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.33

	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7500 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	100 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	10 / -

: conditioned according to ISO 1110

TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET — TECHNYL 4EARTH A5E 236 V30 BK H

Thermal properties

	Condition	Standard	Unit	Value
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	255
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	250
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	240

Burning behaviour

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

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	260 - 285 °C
Recommended mould temperature	80 - 120 °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.