

TECHNICAL DATA SHEET

TECHNYL 4EARTH A2E 236 BK
ECONAMID Plus 66I2 BK



Polyamide 66, impact modified, for injection moulding, black

General

Polymer type	PA66		
Certifications	RoHS		
Feature	impact modified		recycled
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA66-I(REC)		
ISO 16396 designation	PA66,(R>50),MP,S14-020		

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.08
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.8
Water absorption	24 hr, 23°C	ISO 62	%	7.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2350 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	65 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	15 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	14 / -
Rockwell hardness		ISO 2039/2	ScaleR	110 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	175
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
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

	Condition	Standard	Unit	Value
Electrical properties				
Volume resistivity		IEC 62631-3-1	ohm.m	1.0E16
Surface resistivity		IEC 62631-3-1	ohm	1.0E14

Processing conditions				
Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)			

Processing conditions

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.