

TECHNICAL DATA SHEET

TECHNYL 4EARTH A1E 218 V30 BK H



Recycled polyamide 66, reinforced with 30% of glass fiber, heat stabilized, for injection moulding, black

General

Polymer type	PA66
Certifications	RoHS EC 1907/2006 (REACH) UL listed product
Feature	heat-aging stabilized recycled
Applications	automotive applications
Colors available	black
Forms	pellets
Processing technology	injection moulding
Automotive homologations	

Product identification

ISO 1043 abbreviation	PA66(REC)-GF30
ISO 16396 designation	PA66,GF30(R100),MH,S14-100

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.36
Humidity absorption	T=23°C, 50% RH (equivalent ISO 1110)	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23°C, immersion in water, thickness 2mm	ISO 62	%	0.8
Water absorption, saturation			%	5.3
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	1.0 - 1.2

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10000 / 6850
Stress at break		ISO 527-1/-2	MPa	190 / 115
Strain at break		ISO 527-1/-2	%	3 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8700 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	280 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	75 / 83
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	65 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	11 / 13
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	7.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	60 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	9 / -

*: 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, 0.45 MPa	ISO 75	°C	260
Temp. of deflection under load, 1.80 MPa	ISO 75	°C	246

Condition	Standard	Unit	Value
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Burning behaviour

UL Yellow Card availability 1	<u>Click here to have access to the UL Yellow Card availability 1 -> QMFZ2.E44716</u>			
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100mm/min

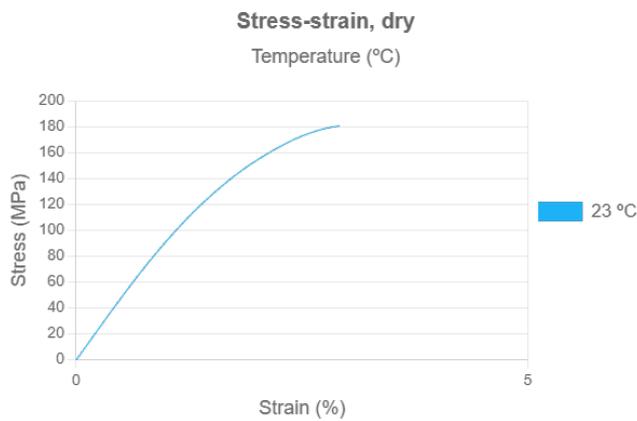
Condition	Standard	Unit	Value
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Electrical properties

Comparative tracking index	Solution A	IEC 60112	V	400.0
CTI performance level category		Sol A		PLC 1

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	270 - 280 °C
Middle temperature	275 - 285 °C
Front temperature	280 - 290 °C
Recommended mould temperature	70 - 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 -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.