TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
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TECHNICAL DATA SHEET

TECHNYL 4EARTH A2E 219 V30 BK H

ECONAMID FL 66G30H1 BK

Recycled polyamide 66, 30% glass fiber reinforced, heat-aging stabilized, for injection moulding, black

General

Certifications	RoHS	
Polymer type	PA66	
Feature	heat-aging stabilized recycled	organic heat stabilized
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66(REC)-GF30
ISO 16396 designation	PA66,GF30(R100),MH,S14-080

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.35
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23°C	ISO 62	%	0.8
Water absorption, saturation			%	5.3

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8500 / 5400
Stress at break	5 mm/min	ISO 527-1/-2	MPa	130 / 85
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / 5
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	35 / 50
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	6.5 / 11
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	30 / 45
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	6 / 10

: 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	255
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	245
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	250

	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	1.0E13
Surface resistivity		IEC 62631-3-1	ohm	1.0E13

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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	90 - 110 °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.