

TECHNICAL DATA SHEET

TECHNYL 4EARTH A2E 219 S15 V15 BK

DOMAMID R 66GB3015H1 BK



Recycled polyamide 66, 30% glass fiber and glass beads, heat-aging stabilized, for injection moulding

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)-(GF15+GB15)
ISO 16396 designation	PA66,(GF+GB)30(R50),MH,S14-070

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.35
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	145.0

Condition	Standard	Unit	Value
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Mechanical properties

dam / cond.*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6800 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	125 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5 / -

*: **conditioned according to ISO 1110**

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Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	262
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Condition	Standard	Unit	Value
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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
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Electrical properties

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	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 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.