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DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL A 218G V30 BK 21N

DOMAMID 66G30HR2 BK

Polyamide 66, 30% glass fiber reinforced, hydrolisis stabilized, for injection moulding, black. This product is available only in Asia and US

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA66	
Feature	heat-aging stabilized glycol resistant	hydrolysis stabilized
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA66-GF30
ISO 16396 designation	PA66,GF30,MHW,S14-100

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cmÂ³	1.37
Humidity absorption	T=23Â°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23Â°C	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	%	0.7 - 0.9
Viscosity number	96% H2SO4	ISO 307	cmÂ³/g	145.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10100 / 6900
Stress at break	5 mm/min	ISO 527-1/-2	MPa	190 / 120
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8000 / 5300

: conditioned according to ISO 1110

	Condition	Standard	Unit	Value
Thermal properties				
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	250
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	250

	Condition	Standard	Unit	Value
Burning behaviour				
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Processing conditions

Drying temperature/time	75-85Â°C / 2-4h (with dew point of dried air < -30 Â°C)
Suggested max moisture	0.2 %
Rear temperature	280 °C
Middle temperature	285 °C
Front temperature	290 °C
Recommended melt temperature	290 °C
Recommended mould temperature	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 -20Â°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 120Â°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.