TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

DOMONYL 1850R33T1U2 GY 426

Polyamide 6, 33% glass fiber reinforced, improved impact resistance, for injection moulding. For America availability only.

General

Polymer type	PA6	
Certifications	RoHS	EC 1907/2006 (REACH)
Feature	impact modified	
Colors available	grey	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I-GF33
ISO 16396 designation	PA6,GF33,MPH,S14-080

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.36
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.1 - 0.2
Molding shrinkage, normal		ISO 294-4, 2577	%	0.7 - 0.8

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Mechanical properties

	Condition	Standard	Unit	Value
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9700 / 5300
Stress at break		ISO 527-1/-2	MPa	130 / 75
Strain at break		ISO 527-1/-2	%	2.3 / 7.7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8500 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	200 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	55 / 65
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m²	55 / 50
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	11 / 22
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	6 / 7

: conditioned according to ISO 1110

Thermal properties

	Condition	Standard	Unit	Value
Melting temperature, 10°C/min		ISO 11357-1	°C	221
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	220
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	210

Burning behaviour

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

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Suggested max moisture	0.2 %

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.

DOMO Engineering Plastics

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.