TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH C1E 216L2 BK H

ECONAMID ORO 6UV3 114 BK

Recycled polyamide 6, UV-stabilized, for injection molding, black

General

Polymer type	PA6	
Feature	UV stabilized not heat stabilized	recycled
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6(REC)
ISO 16396 designation	PA6,(R100),ML1,S14-030

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.13
Humidity absorption	T=23°C, 50% RH	ISO 62	%	3.3 - 3.4
Water absorption	24 hr, 23°C	ISO 62	%	1.9 - 2.0
Water absorption, saturation			%	9.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.4 - 1.6
Molding shrinkage, normal		ISO 294-4, 2577	%	1.35 - 1.55
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm³/10 min	120.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3200 / -
Stress at break		ISO 527-1/-2	MPa	85 / -
Strain at break		ISO 527-1/-2	%	3.5 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2800 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	120 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	4.5 / -

: conditioned according to ISO 1110

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	220

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

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.