

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 216 V25 BK H
ECONAMID FL 6G25 BK



Recycled polyamide 6, 25% glass fiber reinforced, for injection moulding, black

General

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

Product identification

ISO 1043 abbreviation	PA6(REC)-GF25
ISO 16396 designation	PA6,GF25(R100),M,S14-080

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.32
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Condition	Standard	Unit	Value
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Mechanical properties

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Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8000 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	135 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5 / -
Rockwell hardness		ISO 2039/2	ScaleR	120 / -

*: **conditioned according to ISO 1110**

Condition	Standard	Unit	Value
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Thermal properties

Condition	Standard	Unit	Value
Melting temperature, 10°C/min	ISO 11357-1	°C	221
Temp. of deflection under load, 0.45 MPa	ISO 75	°C	215
Temp. of deflection under load, 1.80 MPa	ISO 75	°C	205
Vicat softening temperature	ISO 306	°C	210

Condition	Standard	Unit	Value
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Burning behaviour

Condition	Standard	Unit	Value
Flammability, 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

Condition	Standard	Unit	Value
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	235 - 275 °C
Recommended mould temperature	70 - 120 °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.