

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 216 V20 GY R7045 H
ECONAMID FL 6G20 GYR7045


Recycled polyamide 6, 20% glass fiber reinforced, for injection moulding, grey

General

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

Product identification

ISO 1043 abbreviation	PA6(REC)-GF20		
ISO 16396 designation	PA6,GF20(R100),M,S14-070		

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.26
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.4 - 2.6
Water absorption, saturation			%	6.5
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	135.0

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	Condition	Standard	Unit	Value
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	130 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6100 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	190 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	30 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	25 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4.5 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	221

	Condition	Standard	Unit	Value
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
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)
Suggested max moisture	0.2 %

Processing conditions

Recommended melt temperature	240 - 260 °C
Recommended mould temperature	80 - 90 °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.