

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7800 / 3600
Stress at break	5 mm/min	ISO 527-1/-2	MPa	90 / 45
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / 12
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7000 / 3700
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	145 / 90
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	35 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	30 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	221
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	210
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	180
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	200

	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	1.0E16
Surface resistivity		IEC 62631-3-1	ohm	1.0E14

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	240 - 270 °C
Recommended mould temperature	80 - 90 °C

processing conditions

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

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.