

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 216 S15 V15 Y20 BK
ECONAMID L 6GB3015Y20 BK



Recycled polyamide 6, 30% glass fiber and glass beads, for injection moulding, black

General

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

Product identification

ISO 1043 abbreviation	PA6(REC)-(GF15+GB15)
ISO 16396 designation	PA6,(GF+GB)30(R>50),M,S14-070

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.37
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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	95 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5700 / -
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	4.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	34 / -
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

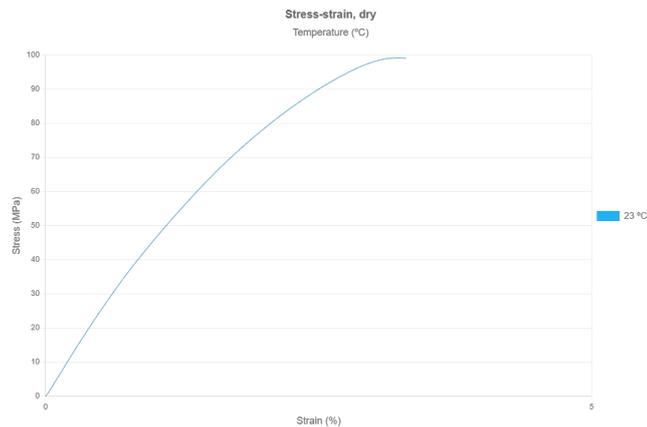
	Condition	Standard	Unit	Value
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

	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)		
Recommended melt temperature	240 - 280 °C		

Processing conditions

Recommended mould temperature	90 - 100 °C
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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.