

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9000 / 5000
Stress at break	5 mm/min	ISO 527-1/-2	MPa	140 / 80
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / 5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7500 / 4600
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	200 / 130
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	40 / 55
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	6 / 14
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	35 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	5.5 / -
Rockwell hardness		ISO 2039/2	ScaleR	122 / -

*: **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	215
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	200
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	210

	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
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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 - 270 °C			
Recommended mould temperature	80 - 100 °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.