TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 236 V30 GY 7528 H

ECONAMID FL 6G30 500 GY77528

Recyled polyamide 6, 30% glass fiber reinforced, improved impact resistance, for injection moulding, black

General

Certifications	RoHS	
Polymer type	PA6	
Feature	impact modified recycled	improved impact resistance(obs) not heat stabilized
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I(REC)-GF30
ISO 16396 designation	PA6-I,GF30(R100),M,S14-080

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.33
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.45
Molding shrinkage, normal		ISO 294-4, 2577	%	2.25 - 2.4

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8500 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	120 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7600 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	170 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	50 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	9 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	43 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	8 / -

: 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	200
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	205

	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

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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	80 °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.