

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 216 BK H
ECONAMID FLX 6 BK



Recycled polyamide 6, for injection moulding, black

General

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

Product identification

ISO 1043 abbreviation	PA6
ISO 16396 designation	PA6,(R100),M,S14-020

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.14
Humidity absorption	T=23°C, 50% RH	ISO 62	%	3.3 - 3.4
Water absorption	24 hr, 23°C	ISO 62	%	1.9 - 2.0
Water absorption, saturation			%	9.1
Melt flow rate, MFR		ISO 1133	g/10 min	10.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2500 / 800
Strain at break	50 mm/min	ISO 527-1/-2	%	25 / 50
Yield stress	50 mm/min	ISO 527-1/-2	MPa	60 / 35
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2150 / 650
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	85 / 25
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / 20
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	NB
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4.5 / 20

*: **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	165
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	60
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	195

	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	1.0E16
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	230 - 260 °C
Recommended mould temperature	60 - 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 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.