TECHNYL® 4EARTH®
Sustainable polyamide

DOMO
caring is our formula

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 216 M20 GY 7520 H

ECONAMID FL 6M20 205 GY77520

Recycled polyamide 6, 20% mineral filler, impact modified, for injection molding, grey

General

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

Product identification

ISO 1043 abbreviation	PA6-I-MD20
ISO 16396 designation	PA6-I,MD20(R100),M1,S14-030

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.26

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2700 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	45 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	35 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2400 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	70 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	6.5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	NB
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	5.5 / -

: 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)

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Processing conditions

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.