

TECHNICAL DATA SHEET

TECHNYL C 116 S15 NC

DOMAMID 6LVB15 300 NC

Polyamide 6, 15% glass beads, improved flowability, for injection moulding, natural color

General

Polymer type	PA6		
Certifications	RoHS	EC 1907/2006 (REACH)	
Feature	improved flowability not heat stabilized	low warpage	
Colors available	natural		
Forms	pellets		
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA6-GB15		
ISO 16396 designation	PA6,GB15,M,S12-030		

Condition	Standard	Unit	Value
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Physical properties

Condition	Standard	Unit	Value	
Density	ISO 1183	g/cm ³	1.23	
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.6
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.9 - 1.1	
Molding shrinkage, normal	ISO 294-4, 2577	%	0.9 - 1.1	
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	>=190.0
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	125.0

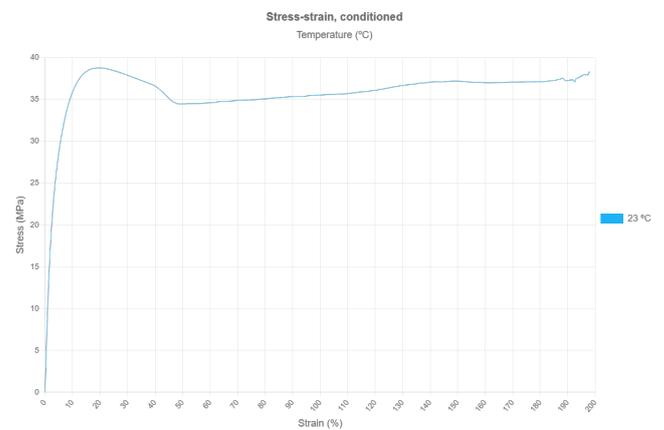
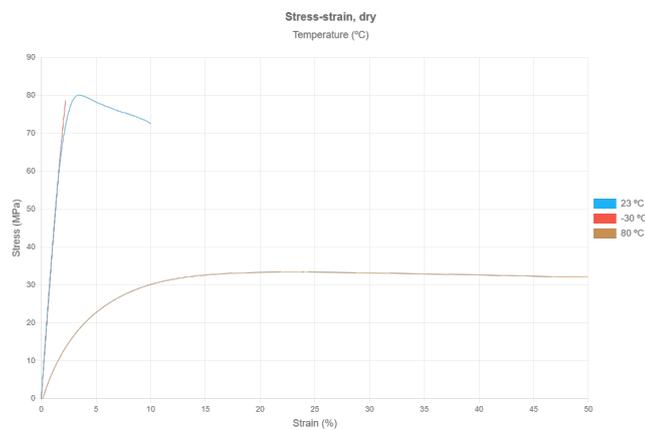
	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3600 / 1050
Stress at break	5 mm/min	ISO 527-1/-2	MPa	70 / 20
Strain at break	5 mm/min	ISO 527-1/-2	%	10 / 150
Yield stress	5 mm/min	ISO 527-1/-2	MPa	75 / 40
Yield strain		ISO 527-1/-2	%	4 / 12
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3100 / 900
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	105 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	19 / 180
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	20 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	3 / -

*: **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	65

	Condition	Standard	Unit	Value
Burning behaviour				
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

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	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.