

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 346 BK H
ECONAMID ORO 6I4 510 BK



Recycled polyamide 6, impact modified, for extrusion, black

General

Polymer type	PA6
Feature	impact modified not heat stabilized recycled
Processing technology	extrusion

Product identification

ISO 1043 abbreviation	PA6-I(REC)
ISO 16396 designation	PA6,(R100),EP,S14-020

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.06
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	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1700 / -
Strain at break		ISO 527-1/-2	%	50 / -
Yield stress		ISO 527-1/-2	MPa	40 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	1500 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	60 / -
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	90 / -
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	80 / -

*: **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

Processing conditions			
Drying temperature/time	75 - 85 °C / 2-4 h (with dew point of dried air < -30 °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

Injection advice

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.