

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 236 MT10 BK
DOMAMID R 6M10 500 BK



Recycled polyamide 6, 10% mineral filler, impact modified, for injection moulding, black

General

Certifications	RoHS
Polymer type	PA6
Feature	impact modified recycled improved impact resistance(obs)
Processing technology	injection moulding

Product identification

ISO 1043 abbreviation	PA6-I-MD10
ISO 16396 designation	PA6-I,MD10(R50),M1,S14-030

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.2
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.1 - 1.3
Molding shrinkage, normal		ISO 294-4, 2577	%	1.2 - 1.4
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	90.0
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	145.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3200 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	70 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3000 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	100 / -
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	8 / -
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	8 / -

*: **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)		

Processing conditions

Recommended melt temperature	240 - 260 °C
Recommended mould temperature	80 - 90 °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.