

TECHNICAL DATA SHEET

## TECHNYL C 116 V15 NC

### DOMAMID 6LVG15 NC

Polyamide 6, 15% glass fiber reinforced, improved flowability, for injection moulding

#### General

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

#### Product identification

ISO 1043 abbreviation	PA6-GF15
ISO 16396 designation	PA6,GF15,M,S12-060

Condition	Standard	Unit	Value
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#### Physical properties

		Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.23
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.5 - 2.6
Water absorption	24 hr, 23°C	ISO 62	%	8.0
Water absorption, saturation			%	8.0
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.4 - 0.6
Molding shrinkage, normal		ISO 294-4, 2577	%	0.9 - 1.1
Viscosity number	96% H2SO4	ISO 307	cm <sup>3</sup> /g	125.0

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5800 / 3400
Stress at break	5 mm/min	ISO 527-1/-2	MPa	120 / 70
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 8
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4800 / 2900
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	190 / 100
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	40 / 60
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	6 / 13
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m <sup>2</sup>	35 / 55
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	6 / 12.5

\*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	221
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	210
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	190
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	205

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
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	1.0E13
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)
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.