

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 238 V15 BK
ECONAMID PLUS 6G15I1H2 BK



Recycled polyamide 6, 15% glass fiber reinforced, heat-aging stabilized, impact modified, for injection molding, black

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA6	
Feature	heat-aging stabilized recycled	impact modified
Applications	automotive applications	
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I(REC)-GF15
ISO 16396 designation	PA6,GF15(R>50),MPH,S14-060

Condition	Standard	Unit	Value
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Physical properties

Condition	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.22
Humidity absorption	T=23°C, 50% RH	%	2.4 - 2.8
Water absorption	24 hr, 23°C	%	1.5 - 1.6
Water absorption, saturation		%	7.5
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.3 - 0.5
Molding shrinkage, normal	ISO 294-4, 2577	%	0.6 - 0.8

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5600 / 3000
Stress at break	5 mm/min	ISO 527-1/-2	MPa	90 / 50
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / 11
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4500 / 2400
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	160 / 80
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	45 / 80
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	35 / 35
Charpy impact strength	-40°C	ISO 179/1eU	kJ/m ²	35 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / 11
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	3 / 4
Charpy notched impact strength	- 40°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	210
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	190

	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
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Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1.0E16
Surface resistivity		IEC 62631-3-1	ohm	1.0E14

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30°C)			
Recommended melt temperature	240 - 270 °C			
Recommended mould temperature	90 - 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.