

TECHNICAL DATA SHEET

TECHNYL C 118 MX15 V25 BK

DOMAMID 6LVGM4025H2 212 BK

Polyamide 6, 40% glass fiber and mineral filler, heat-aging stabilized, improved flowability, for injection moulding, black

General

Polymer type	PA6	
Certifications	RoHS	
Feature	heat-aging stabilized	improved flowability
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-(GF25+MD15)
ISO 16396 designation	PA6,(GF+MD)40,MH,S12-110

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.48
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.8 - 2.2
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.15 - 0.35
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	11000 / 6000
Stress at break		ISO 527-1/-2	MPa	145 / 90
Strain at break		ISO 527-1/-2	%	2.5 / 6
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9500 / 6000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	235 / 150
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	55 / 60
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	50 / 50
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	8.5 / 12.5
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	6.5 / 7

*: **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				
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	240 - 290 °C
Recommended mould temperature	80 - 110 °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.

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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.