

TECHNICAL DATA SHEET

## TECHNYL C 216 V10 NC

### DOMAMID 6G10

Polyamide 6, 10% glass fiber reinforced, for injection moulding

#### General

Certifications	RoHS
Polymer type	PA6
Feature	not heat stabilized
Processing technology	injection moulding

#### Product identification

ISO 1043 abbreviation	PA6-GF10
ISO 16396 designation	PA6,GF10,M,S14-040

Condition	Standard	Unit	Value
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#### Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.19
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.4 - 0.6
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1.0
Viscosity number	96% H2SO4	ISO 307	cm <sup>3</sup> /g	145.0

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	4100 / 2300
Stress at break	5 mm/min	ISO 527-1/-2	MPa	90 / 50
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 10
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3500 / 2000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	120 / 65
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	35 / 65
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	6 / 14
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m <sup>2</sup>	25 / 45
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	5 / 12

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

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	221

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Glow-wire flammability index, GWFI	1-3 mm	IEC 60695-2-12	°C	>= 650
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
Comparative tracking index	Solution A	IEC 60112	V	600.0
CTI performance level category		Sol A		PLC 0

## 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.