

TECHNICAL DATA SHEET

TECHNYL C 118 MX30 BK

DOMAMID 6LVT30H2 BK

Polyamide 6, 30% mineral filler, heat-aging stabilized, improved flowability, for injection moulding, black

General

Polymer type	PA6		
Certifications	RoHS	EC 1907/2006 (REACH)	
Feature	heat-aging stabilized	improved flowability	
Colors available	black		
Forms	pellets		
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA6-MD30
ISO 16396 designation	PA6,MD30,MH,S12-060

Condition	Standard	Unit	Value
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Physical properties

Property	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.38
Humidity absorption	T=23°C, 50% RH (equivalent ISO 1110)	ISO 62	%	2.2 - 2.4
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.5 - 0.7
Molding shrinkage, normal		ISO 294-4, 2577	%	0.35 - 0.55
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	70.0 - 110.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6500 / 2500
Stress at break	50 mm/min	ISO 527-1/-2	MPa	70 / 35
Strain at break	50 mm/min	ISO 527-1/-2	%	2.9 / 25
Yield stress	50 mm/min	ISO 527-1/-2	MPa	70 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6300 / 2600
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	120 / 60
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	33 / 100
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	3 / 7

*: **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	190
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	150

	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 - 280 °C
Recommended mould temperature	60 - 80 °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.