

TECHNICAL DATA SHEET

TECHNYL C 216 S30 BK

DOMAMID 6B30 300 BK

Polyamide 6, 30% glass beads, for injection moulding, black

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA6	
Feature	low warpage	
Colors available	black	natural
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-GB30
ISO 16396 designation	PA6,GB30,M,S14-040

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.37
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.0 - 1.2
Molding shrinkage, normal		ISO 294-4, 2577	%	1.1 - 1.3
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	95.0
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	145.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	4200 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	75 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	6 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3700 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	30 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	3.3 / -

*: **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 - 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.

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.