

TECHNICAL DATA SHEET

## TECHNYL C 216 V18 NC

TECHNYL C 216 V18 NC is a reinforced polyamide 6 with 18% of glass fiber, for injection moulding. This grade has good mechanical properties and offering an excellent combination between thermal and mechanical properties.

### General

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

### Product identification

ISO 1043 abbreviation	PA6-GF18
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Condition	Standard	Unit	Value
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### Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.24
Water absorption	24 hr, 23°C	ISO 62	%	1.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2
Molding shrinkage, normal		ISO 294-4, 2577	%	0.85

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6700 / 3400
Stress at break		ISO 527-1/-2	MPa	150 / 90
Strain at break		ISO 527-1/-2	%	4 / 9
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6500 / 3300
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	55 / 65
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	7 / 23
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	8 / 16

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

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	222
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	180

	Condition	Standard	Unit	Value
<b>Burning behaviour</b>				
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	650

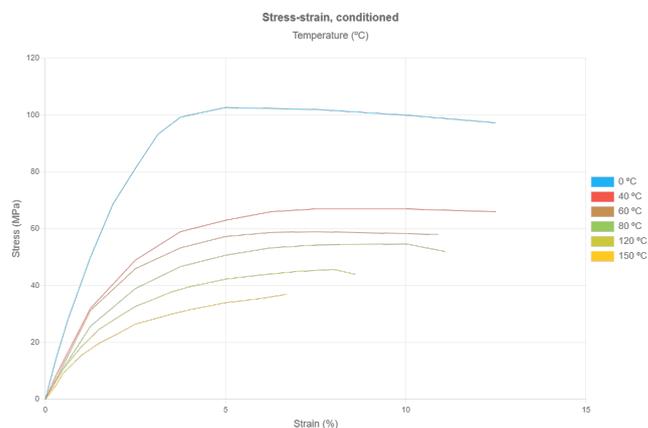
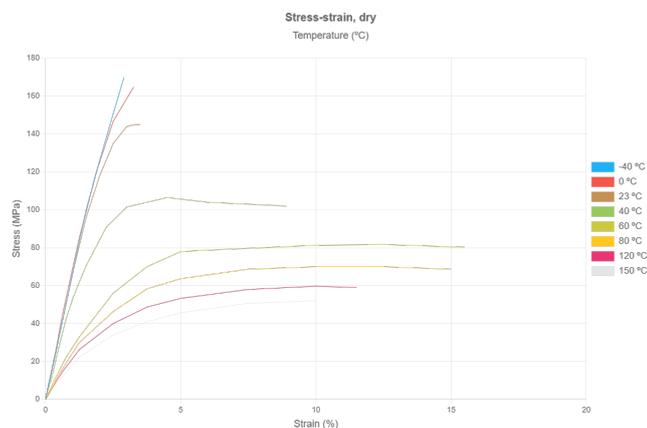
Condition	Standard	Unit	Value
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## Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1.0E13
Surface resistivity		IEC 62631-3-1	ohm	1.0E14
Comparative tracking index	Solution A	IEC 60112	V	550.0
CTI performance level category		Sol A		PLC 1

## Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	240 - 250 °C
Recommended mould temperature	60 - 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.