

TECHNICAL DATA SHEET

TECHNYL C 216 V30 BL 2234 CF

TECHNYL C 216 V30 BL 2234 CF is a polyamide 6, reinforced with 30% of glass fibre, for injection moulding. This grade has good mechanical properties and offering an excellent combination between thermal and mechanical properties.

General

Certifications	UL listed product	EC 1907/2006 (REACH)
Polymer type	PA6	
Applications	general purpose sport	power tool / garden equipment
Colors available	black grey	natural
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-GF30
ISO 16396 designation	PA6,GF30,M1,S14-090

Condition	Standard	Unit	Value
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Physical properties

Property	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.36
Water absorption	24 hr, 23°C	ISO 62	%	1.1

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9600 / 6400
Stress at break		ISO 527-1/-2	MPa	145 / 94
Strain at break		ISO 527-1/-2	%	2.1 / 3.7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7000 / 4600
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	205 / 135
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	25 / 40

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	222
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	218
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	200

	Condition	Standard	Unit	Value
Burning behaviour				
UL Yellow Card availability 1	Click here to have access to the UL Yellow Card availability 1 -> QMFZ2.E44716			
Flammability, 1.5 mm	1.5 mm	UL 94		HB

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

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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.