

TECHNICAL DATA SHEET

TECHNYL C 216 V25 NC

DOMAMID 6G25 300 NC / DOMAMID 6G25

Polyamide 6, 25% glass fiber reinforced, for injection moulding

General

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

Product identification

ISO 1043 abbreviation	PA6-GF25
ISO 16396 designation	PA6,GF25,M,S14-080

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.31
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8300 / 5000
Stress at break	5 mm/min	ISO 527-1/-2	MPa	155 / 95
Strain at break	5 mm/min	ISO 527-1/-2	%	3.2 / 5.5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6100 / 3800
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	230 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	80 / 85
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	11 / 20
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	70 / 85
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	12 / 22

*: **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	215
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	200
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	210

	Condition	Standard	Unit	Value
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
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	1.0E13
Surface resistivity		IEC 62631-3-1	ohm	1.0E14

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	240 - 250 °C
Recommended melt temperature	230 - 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.