

TECHNICAL DATA SHEET

TECHNYL C 216 V30 GY F650 XB

DOMAMID 6G30 GY7F650XB

Polyamide 6, 30% glass fiber reinforced, for injection moulding

General

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

Product identification

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

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.36
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23°C	ISO 62	%	1.4 - 1.5
Water absorption, saturation			%	6.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3 - 0.5
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1.0
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	45.0
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	9500 / 6000
Stress at break	5 mm/min	ISO 527-1/-2	MPa	180 / 110
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / 6
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8500 / 5000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	270 / 160
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	90 / 105
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	75 / 90
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	15 / 25
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	9 / 22
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	80 / 90
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	15 / 25
Rockwell hardness		ISO 2039/2	ScaleR	122 / -

*: **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	220
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	215

Condition	Standard	Unit	Value
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Burning behaviour

UL Yellow Card availability 1	<u>Click here to have access to the UL Yellow Card availability 1 -> QMFZ2.E44716</u>			
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Glow-wire flammability index, GWFI	1-3 mm	IEC 60695-2-12	°C	>= 650
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	1.0E13
Comparative tracking index	Solution A	IEC 60112	V	500.0
CTI performance level category		Sol A		PLC 1

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	240 - 270 °C
Recommended mould temperature	90 - 100 °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.