

TECHNICAL DATA SHEET

TECHNYL C 216 V60 NC

DOMAMID 6LVG60 NC

Polyamide 6, 60% glass fiber reinforced, improved flowability, for injection moulding, natural color

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA6	
Feature	high stiffness	not heat stabilized
Colors available	natural	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-GF60
ISO 16396 designation	PA6,GF60,M,S12-220

Condition	Standard	Unit	Value
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Physical properties

Condition	Standard	Unit	Value	
Density	ISO 1183	g/cm ³	1.68	
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.1
Water absorption	24 hr, 23°C	ISO 62	%	1.1
Water absorption, saturation			%	4.0
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.1 - 0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	0.3 - 0.5
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	125.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	20500 / 12500
Stress at break	5 mm/min	ISO 527-1/-2	MPa	240 / 150
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / 4.5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	18500 / 12000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	370 / 240
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	85 / 95
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	80 / 80
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	17 / 23
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	12 / 13
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	80 / 95
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	17 / 24

*: **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	210
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	210

Condition	Standard	Unit	Value
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Burning behaviour

Condition	Standard	Unit	Value
Flammability, 1.5 mm	UL 94		HB
Glow-wire flammability index, GWFI, 3.0 mm		°C	650
Glow-wire flammability index, GWFI	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

Condition	Standard	Unit	Value
Volume resistivity	IEC 62631-3-1	ohm.m	1.0E16
Surface resistivity	IEC 62631-3-1	ohm	1.0E14
Comparative tracking index	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)
Suggested max moisture	0.2 %
Recommended melt temperature	250 - 280 °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.