

TECHNICAL DATA SHEET

TECHNYL C 216 V25 BK

DOMAMID 6G25 300 BK

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

General

Polymer type	PA6		
Certifications	RoHS	UL listed product	
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	1.32
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.1
Water absorption	24 hr, 23°C	ISO 62	%	>=6.0
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	46.0
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	8400 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	150 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3.2 / -
Yield stress	5 mm/min	ISO 527-1/-2	MPa	150 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6000 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	60 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	7.5 / -

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	221

	Condition	Standard	Unit	Value
Burning behaviour				
UL Yellow Card availability 1	Click here to have access to the UL Yellow Card availability 1 -> E329653-100458649			
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Processing conditions	
Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	250 - 290 °C
Recommended mould temperature	80 - 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.

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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.