TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL C 218 V25 BK 21N

General

Feature	Heat-aging stabilized	
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Automotive Applications Electrical/Electronic Applications	Connectors
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA6-GF25

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.31
Water absorption	24 hr, 23°C	ISO 62	%	1 - 1.2
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8400 / 4700
Stress at break		ISO 527-1/-2	MPa	160 / 95
Strain at break		ISO 527-1/-2	%	3.8 / 8.3
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	70 / 95
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	8 / 25
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	210
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	200
Burning behaviour				
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		<100

TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET **TECHNYL C 218 V25 BK 21N**

	Condition	Standard	Unit	Value

**: conditioned according to ISO 1110*

Processing conditions

Drying temperature/time	80
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

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.