

TECHNICAL DATA SHEET

## TECHNYL C 218 MT25 V15 BK

TECHNYL C 218 MT25 V15 BK is a polyamide 6, reinforced 25 % mineral filler and 15 % of glass fibre, heat stabilized, for injection moulding. This grade offers an excellent planarity of the end product, with good mechanical properties and good dimensional stability.

### General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA6	
Feature	heat-aging stabilized low warpage	high dimensional stability
Applications	automotive applications	
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

### Product identification

ISO 1043 abbreviation	PA6-MD25+GF15
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Condition	Standard	Unit	Value
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### Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm <sup>3</sup>	1.47
Water absorption	24 hr, 23°C	ISO 62	%	0.5
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	9700 / 5500
Stress at break		ISO 527-1/-2	MPa	125 / 70
Strain at break		ISO 527-1/-2	%	2.5 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	4.2 / -

\*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	222

	Condition	Standard	Unit	Value
<b>Electrical properties</b>				
Volume resistivity		IEC 62631-3-1	ohm.m	1.0E14
Surface resistivity		IEC 62631-3-1	ohm	1.0E15

<b>Processing conditions</b>	
Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	235 - 240 °C
Middle temperature	240 - 250 °C
Front temperature	250 - 260 °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) - DOMO Engineering Plastics

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## Injection advice

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.