TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL C 216MSI NC

DOMAMID 6IK1 302 NC

Polyamide 6, impact modified, for injection moulding, natural color

General

Certifications	RoHS	
Polymer type	PA6	
Feature	impact modified	not heat stabilized
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I
ISO 16396 designation	PA6,MP,S14-030

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.6 - 1.8
Molding shrinkage, normal		ISO 294-4, 2577	%	1.4 - 1.6
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm³/10 min	165.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2700 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	65 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2200 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	10 / -

: 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				
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	240 - 280 °C
Recommended mould temperature	60 - 80 °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 unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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.