TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL C 239L1 BK 9279 LP

DOMAMID 6I2LS3H1UV1 701 BK99279

Polyamide 6, heat-aging stabilized, UV-stabilized, impact modified, lasermarkable, for injection moulding

General

Certifications	RoHS	EC 1907/2006 (REACH)
Polymer type	PA6	
Feature	impact modified UV stabilized organic heat stabilized	lasermarkable low temperature impact resistant
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I
ISO 16396 designation	PA6,MPHL1,S14-020

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.11
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.2 - 1.4
Molding shrinkage, normal		ISO 294-4, 2577	%	1.4 - 1.6
Viscosity number	96% H2SO4	ISO 307	cm³/g	145.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2200 / 850
Strain at break	50 mm/min	ISO 527-1/-2	%	35 / 50
Yield stress	50 mm/min	ISO 527-1/-2	MPa	60 / 35
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	1800 / 750
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	75 / 30
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	NB
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	19 / 60
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	NB
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	18 / 60

: 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	145
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	55
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	180

	Condition	Standard	Unit	Value
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

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Electrical properties

	Condition	Standard	Unit	Value
Volume resistivity		IEC 62631-3-1	ohm.m	1.0E13
Surface resistivity		IEC 62631-3-1	ohm	1.0E13

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	240 - 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 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.