

TECHNICAL DATA SHEET

TECHNYL C 246F NC

DOMAMID 6IK4 303 NC

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

General

Certifications	RoHS		
Polymer type	PA6		
Feature	impact modified	high impact resistant	
Processing technology	injection moulding		

Product identification

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

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.07
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.7 - 1.9
Molding shrinkage, normal		ISO 294-4, 2577	%	1.5 - 1.7

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1950 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	40 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	50 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	NB
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	70 / -
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	20 / -

*: **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.

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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.