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DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL C 236L1 V15 BK

DOMAMID 6G15UV1 500

Polyamide 6, 15% glass fiber reinforced, UV-stabilized, improved impact resistance, for injection moulding

General

Polymer type	PA6	
Certifications	RoHS	
Feature	impact modified UV stabilized	improved impact resistance(obs) not heat stabilized
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I-GF15
ISO 16396 designation	PA6-I,GF15,M1L1,S14-060

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.22
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.5 - 2.6
Water absorption	24 hr, 23°C	ISO 62	%	1.5 - 1.6
Water absorption, saturation			%	8.0
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.4 - 0.6
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5700 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	115 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5000 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	185 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	55 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	10 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	50 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	10 / -

: 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	215
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	190
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	210

	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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	Condition	Standard	Unit	Value
Electrical properties				
Volume resistivity		IEC 62631-3-1	ohm.m	1.0E13
Surface resistivity		IEC 62631-3-1	ohm	1.0E13
Comparative tracking index	Solution A	IEC 60112	V	500.0
CTI performance level category		Sol A		PLC 1

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	240 - 260 °C
Recommended mould temperature	80 - 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.