

TECHNICAL DATA SHEET

TECHNYL C 219 V30 BK 9258

DOMAMID 6G30H1 BK99258

Polyamide 6, 30% glass fiber reinforced, heat-aging stabilized, for injection moulding

General

Polymer type	PA6		
Certifications	RoHS	UL listed product	
Feature	organic heat stabilized		
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA6-GF30		
ISO 16396 designation	PA6,GF30,MH,S14-070		

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.36
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.2 - 2.4
Water absorption	24 hr, 23°C	ISO 62	%	1.4 - 1.5
Water absorption, saturation			%	6.1
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	145.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7500 / 5100
Stress at break	5 mm/min	ISO 527-1/-2	MPa	150 / 90
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7700 / 4500
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	210 / 145
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	50 / 80
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	50 / 52
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	8 / 16
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	5 / 6

*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
Burning behaviour				
UL Yellow Card availability 1	<u>Click here to have access to the UL Yellow Card availability 1 -> E170540-225450</u>			
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Flammability, 3.0 mm	3.0 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

	Condition	Standard	Unit	Value
Electrical properties				
Volume resistivity		IEC 62631-3-1	ohm.m	1.0E16
Surface resistivity		IEC 62631-3-1	ohm	1.0E13
Comparative tracking index	Solution A	IEC 60112	V	600.0
CTI performance level category		Sol A		PLC 0
Dielectric strength	1 mm	IEC 60243-1	kV/mm	23.0

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	240 - 270 °C
Recommended mould temperature	90 - 100 °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) - 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.