

TECHNICAL DATA SHEET

## TECHNYL C 249L1 V30 NC

### DOMAMID 6G30I1H1UV1

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

#### General

Certifications	RoHS		
Polymer type	PA6		
Feature	heat-aging stabilized UV stabilized	impact modified organic heat stabilized	
Processing technology	injection moulding		

#### Product identification

ISO 1043 abbreviation	PA6-I-GF30
ISO 16396 designation	PA6-I,GF30,M1L1,S14-090

Condition	Standard	Unit	Value
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#### Physical properties

Condition	Standard	Unit	Value	
Density	ISO 1183	g/cm <sup>3</sup>	1.32	
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.4
Water absorption	24 hr, 23°C	ISO 62	%	1.4 - 1.5
Water absorption, saturation			%	6.1
Molding shrinkage, parallel	ISO 294-4, 2577	%		0.4 - 0.6
Molding shrinkage, normal	ISO 294-4, 2577	%		0.9 - 1.1
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm <sup>3</sup> /10 min	25.0
Viscosity number	96% H2SO4	ISO 307	cm <sup>3</sup> /g	145.0

	Condition	Standard	Unit	Value
<b>Mechanical properties</b>				<b>dam / cond.*</b>
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8600 / 5500
Stress at break	5 mm/min	ISO 527-1/-2	MPa	140 / 100
Strain at break	5 mm/min	ISO 527-1/-2	%	4.5 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7700 / 4700
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	230 / 135
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	100 / 120
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	22 / 38
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m <sup>2</sup>	90 / 110
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m <sup>2</sup>	20 / 35

\*: **conditioned according to ISO 1110**

	Condition	Standard	Unit	Value
<b>Thermal properties</b>				
Melting temperature, 10°C/min		ISO 11357-1	°C	221
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	210
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	195
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	205

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

Condition	Standard	Unit	Value
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## Electrical properties

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)			
Recommended melt temperature	240 - 270 °C			
Recommended mould temperature	90 - 120 °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.