TECHNYL®

DOMO caring is our formula

TECHNICAL DATA SHEET

TECHNYL CR 236 SI S20 BK

DOMAMID 6B20IK2 103 BK

TECHNYL CR 236 SI S20 BK is a polyamide 6, 20% glass beads, low temperature impact modified, for injection moulding, black.

General

Polymer type	PA6	
Certifications	RoHS	EC 1907/2006 (REACH)
Feature	impact modified	
Colors available	black	
Forms	pellets	
Processing technology	injection moulding	

Product identification

ISO 1043 abbreviation	PA6-I-GB20
ISO 16396 designation	PA6-I,GB20,M,S14-020

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.2
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm³/10 min	50.0

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2300 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	45 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	4.5 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	45 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2200 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	120 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	15 / -

: 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.

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.

DOMO Engineering Plastics