

TECHNICAL DATA SHEET

TECHNYL C 246SI V15 NC

DOMAMID 6G15IK1 202 NC

Polyamide 6, 15% glass fiber reinforced, low temperature impact modified, for injection moulding, natural color

General

Certifications	RoHS		
Polymer type	PA6		
Feature	impact modified	not heat stabilized	
Processing technology	injection moulding		

Product identification

ISO 1043 abbreviation	PA6-I-GF15
ISO 16396 designation	PA6,GF15,MP,S14-050

Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.2
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.6 - 0.8
Molding shrinkage, normal		ISO 294-4, 2577	%	0.95 - 1.15
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	40.0

	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5200 / 3100
Stress at break	5 mm/min	ISO 527-1/-2	MPa	110 / 70
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / 14
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4700 / 2500
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	175 / 100
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	80 / -
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	80 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	16 / -
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	8 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	65 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	15 / -

*: **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				
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	1.0E16
Surface resistivity		IEC 62631-3-1	ohm	1.0E14

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	250 - 290 °C
Recommended mould temperature	80 - 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.