

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 216 V35 BK R9004
(Previously ECONAMID PLUS 6G35 BKR9004)

Polyamide 6, 35% glass fiber reinforced, for injection moulding

General

Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA6-GF35
ISO 16396 designation	PA6,GF35(R>50),M1,S14-110

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.41
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm³/10 min	35
Viscosity number	96% H2SO4	ISO 307	cm³/g	145

Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10800 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	140 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	2.3 / -
Yield stress	5 mm/min	ISO 527-1/-2	MPa	140 / -
Yield strain	5 mm/min	ISO 527-1/-2	%	2 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9100 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	64 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	8.5 / -

Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	221

Test run at 23°C if not differently specified, DAM state (dry as moulded).
*: conditioned according to ISO 1110

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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

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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