

TECHNICAL DATA SHEET

TECHNYL C 206F NC

TECHNYL C 206F NC is an unreinforced polyamide PA6, standard for fast injection cycles, for injection moulding. This grade has high fluidity and a good mould release.

General

Feature	Fast molding cycle		
Polymer type	PA6 (Polyamide 6)		
Processing technology	Injection molding		
Certification	RoHS EC 1907/2006 (REACH)	UL-Yellow Card	
Applications	Fasteners Aerosol valve	Fittings	
Colors available	Natural		
Forms	Pellets		

Product identification

ISO 1043 abbreviation	PA6
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Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm³	1.14
Water absorption	24 hr, 23°C	ISO 62	%	1.6
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.1
Molding shrinkage, normal		ISO 294-4, 2577	%	1.2

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3000 / 1100
Stress at break		ISO 527-1/-2	MPa	50 / 60
Strain at break		ISO 527-1/-2	%	15 / 200
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2800 / 1000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	100 / 40
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	4 / 15
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	4 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	5 / 80

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Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	222
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	60

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+014
Comparative tracking index	Solution A	IEC 60112	V	600
CTI performance level category		Sol A		PLC 0

Burning behaviour

UL Yellow Card availability 	Click here to have access to the UL Yellow Card → QMFZ2.E44716			
Flammability, 3.0 mm	3.0 mm	UL 94		V2
Glow-wire ignition temperature, GWIT, 0.75 mm	0.75 mm	IEC 60695-2-13	°C	675

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	235 - 245 °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 unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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.

Disclaimer

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