

TECHNICAL DATA SHEET

TECHNYL C 216 V15 BK 9293
(Previously DOMAMID 6G15 BK99293)

Polyamide 6, 15% glass fiber reinforced, for injection moulding

General

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

Product identification

ISO 1043 abbreviation	PA6-GF15
ISO 16396 designation	PA6,GF15,M1,S14-060

		Condition	Standard	Unit	Value
Physical properties					
Density			ISO 1183	g/cm ³	1.23
Humidity absorption	T=23°C, 50% RH		ISO 62	%	2.5
Water absorption	24 hr, 23°C		ISO 62	%	8
Molding shrinkage, parallel			ISO 294-4, 2577	%	0.4 - 0.6
Molding shrinkage, normal			ISO 294-4, 2577	%	0.8 - 1
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg		ISO 1133	cm ³ /10 min	50
Viscosity number	96% H2SO4		ISO 307	cm ³ /g	145

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	Condition	Standard	Unit	Value
Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6100 / 3800
Stress at break	5 mm/min	ISO 527-1/-2	MPa	120 / 70
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5200 / 3000
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	185 / 100
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	40 / 72
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m²	35 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	6 / 12
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	5 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	35 / 65
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	6 / 11
Rockwell hardness		ISO 2039/2	ScaleR	120 / -

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

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+013
Comparative tracking index	Solution A	IEC 60112	V	500
CTI performance level category		Sol A		PLC 1

Burning behaviour

Flammability, 0.75 mm	0.75 mm	UL 94		HB
Glow-wire flammability index, GWFI	1-3 mm	IEC 60695-2-12	°C	650
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

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

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	240 - 260 °C
Recommended mould temperature	80 - 90 °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.

Disclaimer

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