

TECHNICAL DATA SHEET

TECHNYL C 218 V45 BK
(Previously DOMAMID 6LVG45H2 BK)

Polyamide 6, 45% glass fiber reinforced, heat-aging stabilized, improved flowability, for injection moulding, black

General

Feature	Heat-aging stabilized	Improved flowability
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA6-GF45
ISO 16396 designation	PA6,GF45,M1H,S12-140

	Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.52
Humidity absorption	T=23°C, 50% RH	ISO 62	%	1.8 - 1.9
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	0.5 - 0.7
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	125

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	14000 / 10000
Stress at break	5 mm/min	ISO 527-1/-2	MPa	220 / 150
Strain at break	5 mm/min	ISO 527-1/-2	%	2.7 / 5.8
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	12000 / 8500
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	335 / 240
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	100 / 105
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	95 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	17 / 24
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	13 / -

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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	220
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	200
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	215

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+013

Burning behaviour

Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min
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Test run at 23°C if not differently specified, DAM state (dry as moulded).
*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Suggested max moisture	0.2 %
Rear temperature	235 - 240 °C
Middle temperature	240 - 250 °C
Front temperature	250 - 260 °C
Recommended melt temperature	235 - 260 °C
Recommended mould temperature	60 - 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.

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.

Disclaimer

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