

TECHNICAL DATA SHEET

TECHNYL C 219 MT25 V15 NC

(Previously DOMAMID 6GM4015H1)

Polyamide 6, 40% glass fiber and mineral filler, heat-aging stabilized, for injection moulding

General

Feature	Heat-aging stabilized
Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS
Applications	Automotive Applications
Colors available	Natural
Forms	Pellets

Product identification

ISO 1043 abbreviation	PA6-(GF15+MD25)
ISO 16396 designation	PA6,(GF+MD)40,M1H,S14-080

Condition	Standard	Unit	Value
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Physical properties

Condition	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.47
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.3 - 0.5
Molding shrinkage, normal	ISO 294-4, 2577	%	0.7 - 0.9
Viscosity number	96% H2SO4 ISO 307	cm ³ /g	145

Mechanical properties

dam / cond.*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8000 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	115 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	6500 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	175 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	40 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	4 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	40 / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4 / -

Condition	Standard	Unit	Value
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Thermal properties

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

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

Burning behaviour

Flammability, 0.75 mm	0.75 mm	UL 94		HB
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 natural colored products.
*: 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	240 - 250 °C
Middle temperature	250 - 260 °C
Front temperature	270 - 280 °C
Recommended melt temperature	240 - 280 °C
Recommended mould temperature	60 - 80 °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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