

TECHNICAL DATA SHEET

TECHNYL C 236 V15 BK
(Previously DOMAMID 6G15I1 301 BK)

Polyamide 6, 15% glass fiber reinforced, impact modified, for injection moulding, black

General

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

Product identification

ISO 1043 abbreviation	PA6-I-GF15
ISO 16396 designation	PA6-I,GF15,M1S,\$12-050

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.22
Humidity absorption	T=23°C, 50% RH	ISO 62	%	2.2 - 2.7
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.55 - 0.75
Molding shrinkage, normal		ISO 294-4, 2577	%	0.85 - 1.05

Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	5200 / 2600
Stress at break	5 mm/min	ISO 527-1/-2	MPa	110 / 55
Strain at break	5 mm/min	ISO 527-1/-2	%	4 / 12
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	4000 / 2300
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	180 / 95
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	65 / 80
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	45 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	6.5 / 15
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	5 / -

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	Condition	Standard	Unit	Value
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	200
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	205

Burning behaviour

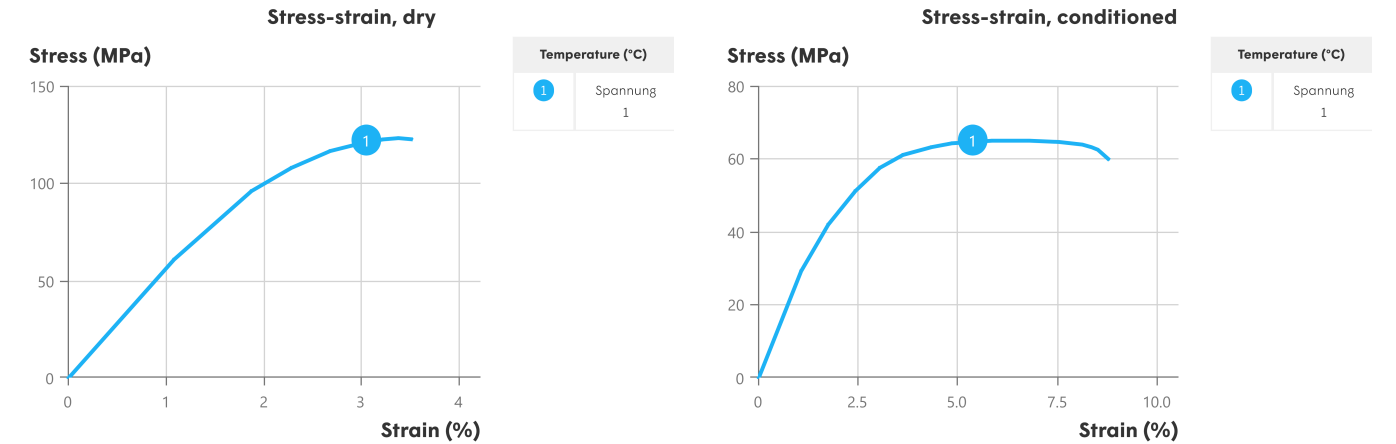
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min
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Test run at 23°C if not differently specified, DAM state (dry as moulded).
*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
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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