

TECHNICAL DATA SHEET

TECHNYL C 259SI V15 BK 9281
(Previously DOMAMID 6G15IK3H1 BK99281)

Polyamide 6, 15% glass fiber reinforced, heat-aging stabilized, low temperature impact modified, for injection moulding

General

Feature	Heat-aging stabilized	Low temperature 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,M1H,S14-040

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.18
Water absorption	24 hr, 23°C	ISO 62	%	2.4
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.65 - 0.85
Molding shrinkage, normal		ISO 294-4, 2577	%	0.75 - 0.95

Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	4600 / 2300
Stress at break	5 mm/min	ISO 527-1/-2	MPa	85 / 50
Strain at break	5 mm/min	ISO 527-1/-2	%	4.5 / 20
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	3600 / 2100
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	70 / 95
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	75 / 70
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	18 / 30
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m ²	11 / 12

TECHNICAL DATA SHEET

TECHNYL C 259SI V15 BK 9281

	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	205
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	165
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	190

Burning behaviour

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).
*: 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.

Disclaimer

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.