TECHNYL® PROTECT
Flame retardants

DOMO
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TECHNICAL DATA SHEET

TECHNYL PROTECT C 52G1 MX25 GY 7035

TECHNYL PROTECT C 52G1 MX25 GY 7035 is a polyamide 6 based on a non-phosphorous and Non-halogenated flame retardant system, reinforced with 25% of mineral filler, heat stabilized, for injection moulding. This phosphorus and halogen free flame retardant grade offers a robust glow wire resistance.

General

Feature	Arc resistant Glow wire resistant	UV-laser markable halogen free flame retardant
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Applications	Electrical/Electronic Applications	
Colors available	Grey	White
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA6-MD25 FR(30)
ISO 16396 designation	PA6,MD25FR(30)0,M1,S14-080

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm³	1.38
Water absorption	24 hr, 23°C	ISO 62	%	1.1
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.35 - 0.45
Molding shrinkage, normal		ISO 294-4, 2577	%	0.6 - 0.7

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	Condition	Standard	Unit	Value
Mechanical properties				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	7000 / 2800
Stress at break		ISO 527-1/-2	MPa	70 / 35
Strain at break		ISO 527-1/-2	%	2.2 / 30
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5500 / 2200
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	100 / 45
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	30 / 70
Charpy impact strength		ISO 179/1eU	kJ/m²	3 / 6
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	1.5 / -
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	220
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	200
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	120
Electrical properties				
Comparative tracking index	Solution A	IEC 60112	V	600
Dielectric strength	1 mm	IEC 60243-1	kV/mm	34
Burning behaviour				
Flammability, 0.75 mm	0.75 mm	UL 94		V2
Flammability, 1.5 mm	1.5 mm	UL 94		V2
Flammability, 3.0 mm	3.0 mm	UL 94		V2
Glow-wire flammability index, GWFI, 0.75 mm	0.75 mm	IEC 60695-2-12	°C	960
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	960
Glow-wire flammability index, GWFI, 3.0 mm	3.0 mm	IEC 60695-2-12	°C	960
Glow-wire ignition temperature, GWIT, 0.75 mm	0.75 mm	IEC 60695-2-13	°C	700
Glow-wire ignition temperature, GWIT, 1.5 mm	1.5 mm	IEC 60695-2-13	°C	725
Oxygen index			%	29
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		<100

**: conditioned according to ISO 1110*

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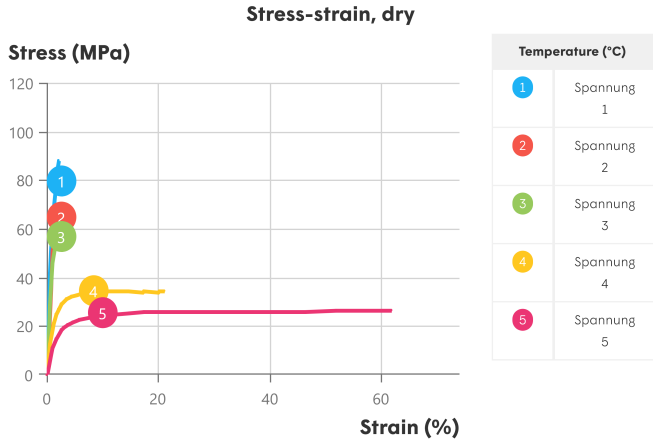
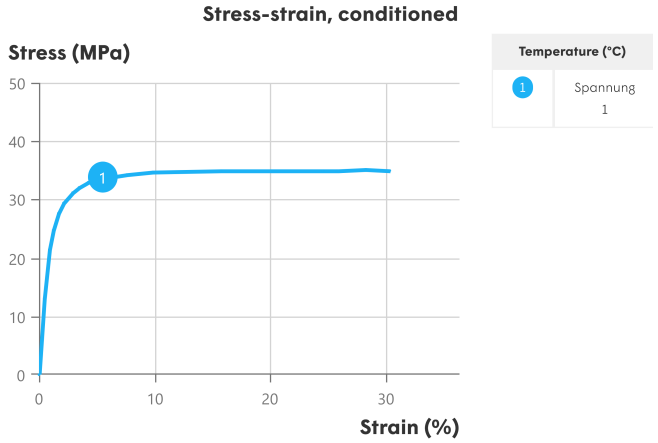
Processing conditions

Drying temperature/time	80
Suggested max moisture	0.1 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	235 - 245 °C
Recommended mould temperature	60 - 90 °C





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

All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, Domo recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, Domo advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. 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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