

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 219 V35 BK H
(Previously ECONAMID FL 6G35H1 BK)

Polyamide 6, 35% glass fiber reinforced, heat-aging stabilized, for injection moulding, black

General

Feature	Heat-aging stabilized
Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA6-GF35
ISO 16396 designation	PA6,GF35(R100),M1H,S14-100

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.41
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	0.7 - 0.9
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	135

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10000 / 6900
Stress at break	5 mm/min	ISO 527-1/-2	MPa	145 / 95
Strain at break	5 mm/min	ISO 527-1/-2	%	2.5 / 5.5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8500 / 5500
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	210 / 135
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	45 / 60
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	6.5 / 11
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	40 / 55
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	6.5 / 10.5
Rockwell hardness		ISO 2039/2	ScaleR	122 / -

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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	215
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	205
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	210

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 black products.
*: 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	240 - 270 °C
Recommended mould temperature	90 - 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. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

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