

TECHNICAL DATA SHEET

TECHNYL 4EARTH C5E 346 BK H
(Previously ECONAMID ORO 6I4 510 BK)

Polyamide 6, impact modified, for extrusion, black

General

| | | | |
|-----------------------|-------------------|----------------------|--|
| Feature | Impact modified | | |
| Polymer type | PA6 (Polyamide 6) | | |
| Processing technology | Extrusion | | |
| Certification | RoHS | EC 1907/2006 (REACH) | |
| Colors available | Black | | |
| Forms | Pellets | | |

Product identification

| | |
|-----------------------|------------------------|
| ISO 1043 abbreviation | PA6-I |
| ISO 16396 designation | PA6-I,(R100),E,S14-020 |

| | Condition | Standard | Unit | Value |
|--|-----------|----------|------|-------|
|--|-----------|----------|------|-------|

Physical properties

| | | | | |
|---------|--|----------|-------|------|
| Density | | ISO 1183 | g/cm³ | 1.06 |
|---------|--|----------|-------|------|

Mechanical properties

| | | | | dam / cond.* |
|---------------------------------------|----------|--------------|-------|--------------|
| Tensile modulus | 1 mm/min | ISO 527-1/-2 | MPa | 1700 / - |
| Strain at break | | ISO 527-1/-2 | % | > 50 / - |
| Yield stress | | ISO 527-1/-2 | MPa | 40 / - |
| Flexural modulus, ISO 178 | 2 mm/min | ISO 178 | MPa | 1500 / - |
| Flexural strength, ISO 178 | 2 mm/min | ISO 178 | MPa | 60 / - |
| Charpy impact strength, +23°C | +23°C | ISO 179/1eU | kJ/m² | NB / - |
| Charpy notched impact strength, +23°C | +23°C | ISO 179/1eA | kJ/m² | 90 / - |
| Izod impact strength, +23°C | +23°C | ISO 180/1U | kJ/m² | NB / - |
| Izod notched impact strength, +23°C | +23°C | ISO 180/1A | kJ/m² | 80 / - |

Thermal properties

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

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| | Condition | Standard | Unit | Value |
|-------------------------------------|-----------|-----------|------|-------|
| Burning behaviour | | | | |
| Flammability, 0.75 mm | 0.75 mm | UL 94 | | HB |
| Burning rate, FMVSS, Thickness 1 mm | | FMVSS 302 | | <100 |

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 / 2-4 h (with dew point of dried air < -30 °C) |
|-------------------------|---|

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