

TECHNICAL DATA SHEET

TECHNYL C 216 V25 GY 7488
(Previously DOMAMID 6G25)

Polyamide 6, 25% glass fiber reinforced, for injection moulding

General

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

Product identification

ISO 1043 abbreviation	PA6-GF25
ISO 16396 designation	PA6,GF25,M1,S14-080

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm³	1.31
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3 - 0.5
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1
Viscosity number	96% H2SO4	ISO 307	cm³/g	145

Mechanical properties				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	8500 / 5100
Stress at break	5 mm/min	ISO 527-1/-2	MPa	160 / 95
Strain at break	5 mm/min	ISO 527-1/-2	%	3.5 / 7
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	7300 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	230 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	75 / 90
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	13 / 22
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	70 / 85
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	12 / 22

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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	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 natural colored 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.

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