

TECHNICAL DATA SHEET

TECHNYL C 216 V35 NC

(Previously TECHNYL C 216 V35 NATURAL / DOMAMID 6G35 310 NC / DOMAMID 6G35 300 NC)



TECHNYL C 216 V35 NC is a polyamide PA6, reinforced with 35 % of glass fibre, for injection moulding. This grade has good mechanical properties and offering an excellent combination between thermal and mechanical properties.

General

Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS EC 1907/2006 (REACH)	UL-Yellow Card
Applications	Electrical/Electronic Applications White Goods & Small Appliances PC / laptop / tablet	home & office furniture Wire & Cable
Colors available	Black	Natural
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA6-GF35
ISO 16396 designation	PA6,GF35,M1,S14-110

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.38
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal		ISO 294-4, 2577	%	0.8 - 1

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	Condition	Standard	Unit	Value
Mechanical properties			dam / cond.*	
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10800 / 7000
Stress at break		ISO 527-1/-2	MPa	185 / 115
Strain at break		ISO 527-1/-2	%	3 / 5.5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	10000 / 6700
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	275 / 170
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m²	90 / 100
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m²	85 / 95
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m²	14 / 15
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m²	12 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m²	85 / 100
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m²	15 / 25
Rockwell hardness		ISO 2039/2	ScaleR	122 / -

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	220
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	210
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	215

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+013
Surface resistivity		IEC 62631-3-1	ohm	1E+014
Comparative tracking index	Solution A	IEC 60112	V	400
CTI performance level category		Sol A		PLC 1

Burning behaviour

UL Yellow Card availability 	Click here to have access to the UL Yellow Card → QMFZ2.E44716			
Flammability, 1.5 mm	1.5 mm	UL 94		HB
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	650
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		<100

*: conditioned according to ISO 1110

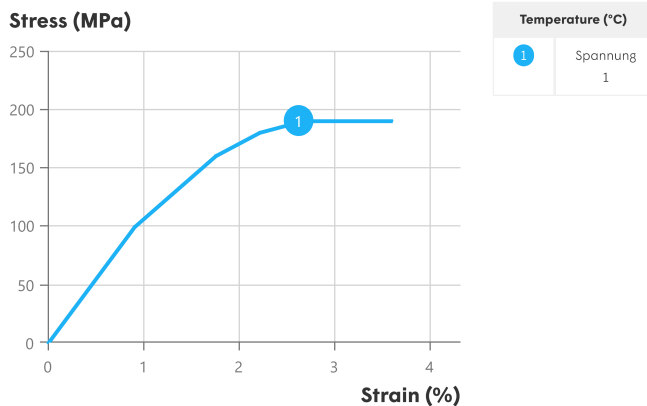
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Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	240 - 250 °C
Recommended melt temperature	230 - 250 °C
Recommended mould temperature	60 - 90 °C

Stress-strain, dry



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

For reinforced polyamides, Domo recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 / 1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 / 1.2379 (DIN Norm). 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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