

TECHNICAL DATA SHEET

TECHNYL C 246F BK
(Previously DOMAMID 6IK4 301 BK)

Polyamide 6, low temperature impact modified, for injection moulding, black

General

Feature	Low temperature impact modified
Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA6-I
ISO 16396 designation	PA6-I,M1,S14-020

Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.07
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	60

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1850 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	40 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	40 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	50 / -
Yield strain		ISO 527-1/-2	%	5 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	NB / -
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	NB / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	55 / -

Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	221
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Test run at 23°C if not differently specified, DAM state (dry as moulded).
*: 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 - 280 °C
Recommended mould temperature	60 - 80 °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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