

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
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Physical properties

Density		ISO 1183	g/cm ³	1.06
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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/m ²	NB / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	90 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	NB / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	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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