

TECHNICAL DATA SHEET

TECHNYL STAR S 219 V30 NC
(Previously DOMAMID VHF 6G30H1)

Polyamide 6, 30% glass fiber reinforced, heat-aging stabilized, high flowability, improved surface finish, for injection moulding

General

Feature	Heat-aging stabilized	High flowability, improved surface finish
Polymer type	PA6 (Polyamide 6)	
Processing technology	Injection molding	
Certification	RoHS	EC 1907/2006 (REACH)
Colors available	Natural	White
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA6-GF30
ISO 16396 designation	PA6,GF30,M1H,S10-090

Condition	Standard	Unit	Value
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Physical properties

Condition	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.37
Molding shrinkage, parallel	ISO 294-4, 2577	%	0.2 - 0.4
Molding shrinkage, normal	ISO 294-4, 2577	%	0.8 - 1

Mechanical properties

dam / cond.*

Condition	Standard	Unit	Value	
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10000 / 5500
Stress at break	5 mm/min	ISO 527-1/-2	MPa	170 / 100
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 5
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	8500 / 4900
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	250 / 155
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	70 / 95
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	12 / 23
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	55 / 58
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	11 / 23

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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	205
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)
Suggested max moisture	0.2 %
Rear temperature	230 - 235 °C
Middle temperature	235 - 240 °C
Front temperature	245 °C
Recommended melt temperature	230 - 245 °C
Recommended mould temperature	60 - 90 °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.

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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