

TECHNICAL DATA SHEET

**TECHNYL 4EARTH C2E 216 V35 BK R9004**  
(Previously ECONAMID PLUS 6G35 BKR9004)

Polyamide 6, 35% glass fiber reinforced, for injection moulding

**General**

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

**Product identification**

ISO 1043 abbreviation	PA6-GF35
ISO 16396 designation	PA6,GF35(R>50),M1,S14-110

Condition	Standard	Unit	Value
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**Physical properties**

Condition	Standard	Unit	Value	
Density	ISO 1183	g/cm <sup>3</sup>	1.41	
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm <sup>3</sup> /10 min	35
Viscosity number	96% H2SO4	ISO 307	cm <sup>3</sup> /g	145

**Mechanical properties**

dam / cond.\*

Condition	Standard	Unit	Value	
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	10800 / -
Stress at break	5 mm/min	ISO 527-1/-2	MPa	140 / -
Strain at break	5 mm/min	ISO 527-1/-2	%	2.3 / -
Yield stress	5 mm/min	ISO 527-1/-2	MPa	140 / -
Yield strain	5 mm/min	ISO 527-1/-2	%	2 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	9100 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	64 / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	8.5 / -

**Thermal properties**

Condition	Standard	Unit	Value
Melting temperature, 10°C/min	ISO 11357-1	°C	221

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	250 - 290 °C
Recommended mould temperature	80 - 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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