

TECHNICAL DATA SHEET

**TECHNYL 4EARTH C2E 216 V15 BK H**  
(Previously ECONAMID FL 6G15 BK)

Polyamide 6, 15% glass fiber reinforced, for injection moulding, black

**General**

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

**Product identification**

|                       |                           |
|-----------------------|---------------------------|
| ISO 1043 abbreviation | PA6-GF15                  |
| ISO 16396 designation | PA6,GF15(R100),M1,S14-050 |

|                             | Condition | Standard        | Unit              | Value     |
|-----------------------------|-----------|-----------------|-------------------|-----------|
| <b>Physical properties</b>  |           |                 |                   |           |
| Density                     |           | ISO 1183        | g/cm <sup>3</sup> | 1.22      |
| Molding shrinkage, parallel |           | ISO 294-4, 2577 | %                 | 0.3 - 0.5 |
| Molding shrinkage, normal   |           | ISO 294-4, 2577 | %                 | 0.7 - 0.9 |

**Mechanical properties**

|                                       |          |              |                   | dam / cond.* |
|---------------------------------------|----------|--------------|-------------------|--------------|
| Tensile modulus                       | 1 mm/min | ISO 527-1/-2 | MPa               | 5000 / -     |
| Stress at break                       | 5 mm/min | ISO 527-1/-2 | MPa               | 115 / -      |
| Strain at break                       | 5 mm/min | ISO 527-1/-2 | %                 | 3 / -        |
| Flexural modulus, ISO 178             | 2 mm/min | ISO 178      | MPa               | 4700 / -     |
| Flexural strength, ISO 178            | 2 mm/min | ISO 178      | MPa               | 175 / -      |
| Charpy impact strength, +23°C         | +23°C    | ISO 179/1eU  | kJ/m <sup>2</sup> | 30 / -       |
| Charpy notched impact strength, +23°C | +23°C    | ISO 179/1eA  | kJ/m <sup>2</sup> | 4 / -        |
| Izod impact strength, +23°C           | +23°C    | ISO 180/1U   | kJ/m <sup>2</sup> | 20 / -       |
| Izod notched impact strength, +23°C   | +23°C    | ISO 180/1A   | kJ/m <sup>2</sup> | 4.5 / -      |
| Rockwell hardness                     |          | ISO 2039/2   | ScaleR            | 120 / -      |

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|--|--------------|-------------|------|-------|
| <b>Thermal properties</b>                |              |             |      |       |
| Melting temperature, 10°C/min            |              | ISO 11357-1 | °C   | 221   |
| Temp. of deflection under load, 0.45 MPa | 0.45 MPa     | ISO 75      | °C   | 205   |
| Temp. of deflection under load, 1.80 MPa | 1.80 MPa     | ISO 75      | °C   | 190   |
| 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 |
|-----------------------|---------|-------|--|----|

*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 / 2-4h (with dew point of dried air < -30 °C) |
| Recommended melt temperature  | 240 - 260 °C  |
| Recommended mould temperature | 80 - 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. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.*

**Disclaimer**

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