

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 / -

**TECHNICAL DATA SHEET**

**TECHNYL 4EARTH C2E 216 V15 BK H**

	Condition	Standard	Unit	Value
<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**

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.