

## TECHNICAL DATA SHEET

# TECHNYL C 246F NC

(Previously DOMAMID 6IK4 303 NC)

Polyamide 6, low temperature impact modified, for injection moulding, natural color

### General

Feature	Low temperature impact modified
Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS

### Product identification

ISO 1043 abbreviation	PA6-I
ISO 16396 designation	PA6-I,M1,S14-020

	Condition	Standard	Unit	Value
<b>Physical properties</b>				
Density		ISO 1183	g/cm <sup>3</sup>	1.07
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.7 - 1.9
Molding shrinkage, normal		ISO 294-4, 2577	%	1.5 - 1.7

### Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1950 / -
Stress at break	50 mm/min	ISO 527-1/-2	MPa	40 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	50 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	NB / -
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m <sup>2</sup>	NB / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	70 / -
Charpy notched impact strength, -30°C	-30°C	ISO 179/1eA	kJ/m <sup>2</sup>	20 / -

### Thermal properties

Melting temperature, 10°C/min		ISO 11357-1	°C	221
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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	240 - 280 °C
Recommended mould temperature	60 - 80 °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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