

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 216M BK
(Previously ECONAMID PLUS 6I1 BK)

Polyamide 6, impact modified, for injection moulding, black

General

Feature	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,(R>50),M1,S14-030

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.13
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.1 - 1.3
Molding shrinkage, normal		ISO 294-4, 2577	%	1.4 - 1.6
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	135

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	2700 / -
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / -
Yield stress	50 mm/min	ISO 527-1/-2	MPa	65 / -
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2400 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	NB / -
Charpy impact strength, -30°C	-30°C	ISO 179/1eU	kJ/m ²	NB / -
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	12 / -
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	NB / -
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	11 / -

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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	155
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	55
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	185

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 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	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. These TECHNYL grades are not recommended for injection moulding hot runner systems with a diameter below 1mm.

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