

TECHNICAL DATA SHEET

TECHNYL 4EARTH C2E 219 MT20 V10 BK
(Previously ECONAMID PLUS 6GM3010H1 BK)

Polyamide 6, 30% glass fiber and mineral filler, heat-aging stabilized, for injection moulding, black

General

Feature	Heat-aging stabilized
Polymer type	PA6 (Polyamide 6)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA6-(GF10+MD20)
ISO 16396 designation	PA6,(GF+MD)30(R>50),M1H,S14-060

	Condition	Standard	Unit	Value
Physical properties				
Density		ISO 1183	g/cm ³	1.36
Molding shrinkage, parallel		ISO 294-4, 2577	%	0.3 - 0.5
Molding shrinkage, normal		ISO 294-4, 2577	%	0.7 - 0.9
Melt volume-flow rate, MVR, 5.0 kg	275°C, 5kg	ISO 1133	cm ³ /10 min	75
Viscosity number	96% H2SO4	ISO 307	cm ³ /g	135

Mechanical properties

				dam / cond.*
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	6000 / 3500
Stress at break	5 mm/min	ISO 527-1/-2	MPa	100 / 60
Strain at break	5 mm/min	ISO 527-1/-2	%	3 / 10
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	5300 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	150 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU	kJ/m ²	30 / 90
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	5 / 10
Izod impact strength, +23°C	+23°C	ISO 180/1U	kJ/m ²	25 / 85
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4.5 / 10

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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	205
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	175
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	200

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).
: 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 - 270 °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.

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