

Product Texts

Partially recycled PA6 flame retardant injection moulding grade, halogen free. 20% glass-fibre-reinforced. Black colour.

The recycled material has been developed to reduce its environmental impact in comparison to traditional virgin options. Suitable for parts requiring fire retardancy along with medium stiffness and enhanced mechanical resistance. Tested V-2 at 0.8 mm according to UL-94.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	5200 / -	MPa	ISO 527
^[C] Stress at break	80 / -	MPa	ISO 527
^[C] Strain at break	10.6 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	40 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	4 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	1E13 / -	Ohm*m	IEC 62631-3-1

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1310 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, Halogen-free

Delivery form

Granules, Black

Certifications

Recycled Resin Content

Additives

Release agent

Regional Availability

Europe

Other text information

Injection molding

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Injection Molding Processing Parameters

Melt Temperature
240 - 280°C

Mold Temperature
80 - 90°C

Injection Speed
medium-high