RENYCLE S GF2501 HF0 3033 BK

PA6-GF25 RadiciGroup High Performance Polymers

Product Texts

Partially recycled PA6 flame retardant injection moulding grade, halogen and red phosphorus free. 25% glass-fibre-reinforced. Laser markable. 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-0 at 0.8 mm according to UL-94.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**9400 / -**	MPa	ISO 527
[C] Stress at break	**120 / -**	MPa	ISO 527
[C] Strain at break	**2.9 / -**	%	ISO 527
[C] Charpy impact strength, +23°C	**50 / -**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**7 / -**	kJ/m²	ISO 179/1eU

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**217 / ***	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**195 / ***	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**210 / ***	°C	ISO 306
[C] Burning Behav. at 1.5 mm nom. thickn.	**V-0 / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-
[C] Burning Behav. at thickness h	**V-0 / ***	class	IEC 60695-11-10
Thickness tested	**0.4 / ***	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Volume resistivity	**1E13 / -**	Ohm*m	IEC 62631-3-1
[C] Comparative tracking index	**500 / -**	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Density	**1380 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Characteristics

Processing
Injection Molding

Delivery form
Granules, Black

Additives
Release agent

Special Characteristics
Flame retardant, Halogen-free, Phosphorus-free

Features
Laser Markable

Certifications
Recycled Resin Content

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	Mold Temperature	Injection Speed
240 - 280°C	80 - 90°C	medium-high