

Product Texts

Partially recycled PA6 injection moulding grade. Black colour.

The recycled material has been developed to reduce its environmental impact in comparison to traditional virgin options.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	1.1 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.2 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	3000 / -	MPa	ISO 527
^[C] Yield stress	80 / -	MPa	ISO 527
^[C] Yield strain	4.3 / -	%	ISO 527
^[C] Nominal strain at break	15 / -	%	ISO 527
^[C] Charpy notched impact strength, +23°C	6 / -	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]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1130 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Certifications

Recycled Resin Content

Delivery form

Granules, Black

Regional Availability

Europe

Additives

Release agent

Other text information

Injection molding

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. 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
70 - 80°C

Injection Speed
medium