

**Product Texts**

Partially recycled PA6 30% glass-fibre-reinforced injection moulding grade. Heat stabilized. Black colour.

The recycled material has been developed to reduce its environmental impact in comparison to traditional virgin options. Suitable for parts requiring high stiffness and good mechanical strength along with good heat-ageing resistance.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	<b>0.3 / *</b>	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	<b>0.8 / *</b>	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>9350 / -</b>	MPa	ISO 527
<sup>[C]</sup> Stress at break	<b>150 / -</b>	MPa	ISO 527
<sup>[C]</sup> Strain at break	<b>3 / -</b>	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>70 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	<b>8.5 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>217 / *</b>	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	<b>200 / *</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	<b>HB / *</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8 / *</b>	mm	-

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	<b>7 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>2 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1350 / -</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

Heat stabilized or stable to heat

**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 0.15%. 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	Mold Temperature	Injection Speed
240 - 280°C	80 - 90°C	medium-high