

Product Texts

Recycled PA6 injection moulding grade. Toughened. Heat stabilized. 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	1.4 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.6 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2500 / 850	MPa	ISO 527
^[C] Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	16 / 90	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] Temp. of deflection under load, 1.80 MPa	60 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	9.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2.6 / *	%	Sim. to ISO 62
^[C] Density	1120 / -	kg/m ³	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	70 - 80°C	medium