

# RENYCLE S T203K 3030 BK

PROVISIONAL

## DESCRIPTION

Partially recycled PA6 injection moulding grade. Toughened. Heat stabilized. Black colour.

This material has been developed to reduce its environmental impact compared to first-choice grades, through the recovery of post-consumer (end-of-life) components previously classified as waste.

ISO 1043: PA6-IT

*THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS*

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

## MATERIAL HANDLING AND PROCESSING

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

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet  
ROHS compliant 2011/65/EU and following amendments

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PROPERTY	STANDARD	UNIT	VALUE	DAM*	Cond**
<b>PHYSICAL PROPERTIES</b>					
Density		kg/m <sup>3</sup>	1120		
Melt Flow Rate	250/2.16 <sup>[1]</sup>	g/10min	20		
Moulding shrinkage - Parallel / Normal	250 /80 /60 <sup>[2]</sup>	%	1.4 / 1.6		
<b>MECHANICAL PROPERTIES</b>					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2500	
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	65	
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	>20	
Flexural Modulus	2mm/min	ISO 178	MPa	2450	
Flexural Strength	2mm/min	ISO 178	MPa	100	
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	N	
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	12.5	
<b>THERMAL PROPERTIES</b>					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220	
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	60	

\*: DAM = Dry As Moulded state according to ISO 16396-2 \*\*: Cond = Conditioned state similar to ISO 1110 1: Temperature [°C] / Load [kg] 2: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]