

# RENYCLE S GF3004K 3033 BK

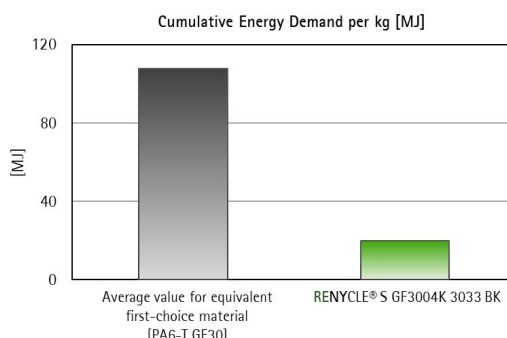
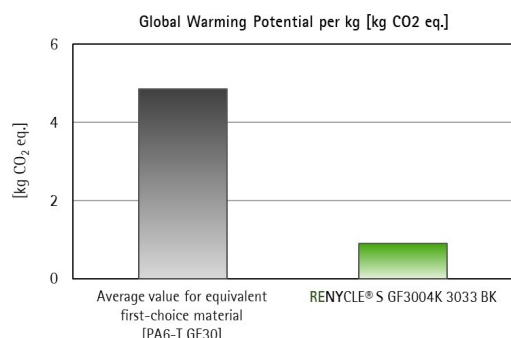
PROVISIONAL

## DESCRIPTION

Recycled PA6 30% glass-fibre injection moulding grade. Heat stabilized. Black colour.

Post-industrial grade with low environmental impact compared to top-grade materials. Suitable for parts requiring medium stiffness and improved mechanical resistance.

ISO 1043: PA6-T GF30



Note: The values of Environmental Performances are related to the issue date of the Technical Data Sheet.

**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. 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  
260 - 280°C

Mold Temperature  
80 - 90°C

Injection Speed  
medium-high

## 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	ISO 1183	kg/m <sup>3</sup>	1370	
Water Absorption, immersion at 23°C	2mm ISO 62	%	7	
Moisture Absorption 23°C - 50%RH	2mm ISO 62	%	2	
<b>MECHANICAL PROPERTIES</b>				
Tensile Modulus	1mm/min ISO 527-2/1A	MPa	9300	5400
Stress at Break	5mm/min ISO 527-2/1A	MPa	135	85
Strain at Break	5mm/min ISO 527-2/1A	%	2,6	3,6
Flexural Modulus	2mm/min ISO 178	MPa	8400	4700
Flexural Strength	2mm/min ISO 178	MPa	210	135
Charpy Impact Strength	+23°C ISO 179/1eU	kJ/m <sup>2</sup>	55	70
Charpy Notched Impact Strength	+23°C ISO 179/1eA	kJ/m <sup>2</sup>	8	12
<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	190	
Heat Deflection Temperature	0.45 MPa ISO 75/2Bf	°C	215	
<b>FLAMMABILITY PROPERTIES</b>				
Flammability	0,8mm UL 94	class	HB	
<b>ELECTRICAL PROPERTIES</b>				
Volume Resistivity	500V IEC 60093	Ohm*m	1E13	
Surface Resistivity	500V IEC 60093	Ohm	1E12	

\*: DAM = Dry As Moulded state according to ISO 16396-2 \*\*: Cond = Conditioned state similar to ISO 1110