

RENYCLE S GF3003 3033 BK

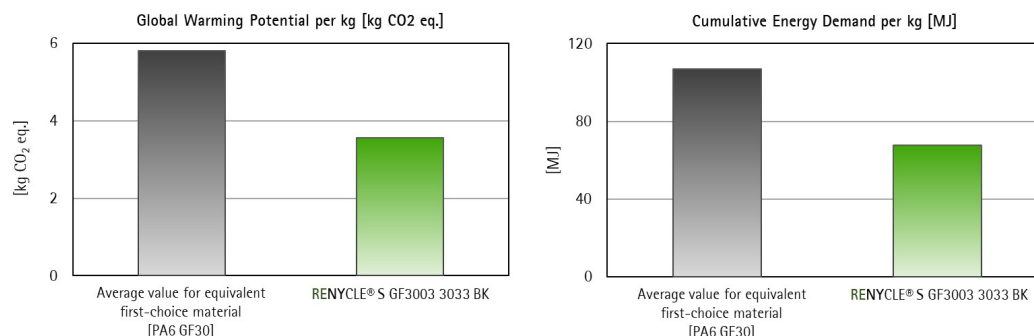
PRELIMINARY

DESCRIPTION

Partially recycled PA6 30% glass-fibre-reinforced injection moulding grade. 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. Suitable for parts requiring high stiffness and good mechanical resistance.

ISO 1043: PA6 GF30



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

THE CHARACTERISTICS SHOWN HERE MUST BE CONSIDERED PRELIMINARY AND INDICATIVE FOR A PRODUCT AT DEVELOPMENTAL STAGE

REGIONAL AVAILABILITY: Europe

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
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**
<i>PHYSICAL PROPERTIES</i>					
Density	ISO 1183	kg/m ³	1.36		
<i>MECHANICAL PROPERTIES</i>					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	9500	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	150	
Strain at Break	5mm/min	ISO 527-2/1A	%	3.4	
Flexural Modulus	2mm/min	ISO 178	MPa	7700	
Flexural Strength	2mm/min	ISO 178	MPa	225	
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	75	
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	10	
<i>THERMAL PROPERTIES</i>					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	215	

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