

RENYCLE S GF2501 HFO 3033 BK

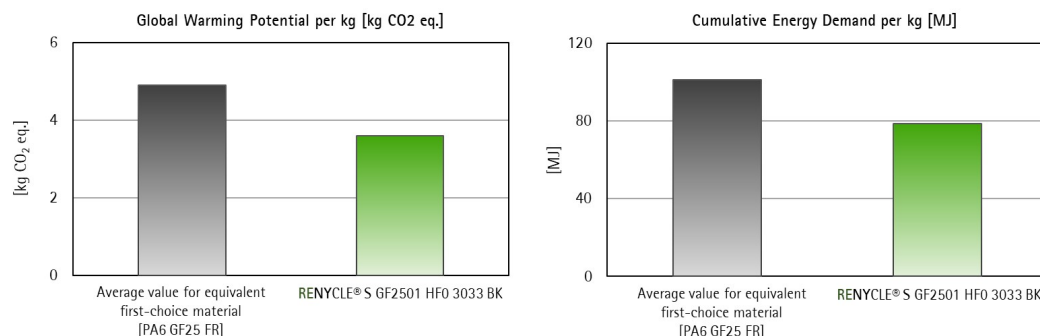
PRELIMINARY

DESCRIPTION

Partially recycled PA6 flame retardant injection moulding grade, halogen and red phosphorus free. 25% glass-fibre-reinforced. Laser markable. 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 fire retardancy along with medium stiffness and good mechanical resistance. Tested V-0 at 0.8 mm according to UL-94.

ISO 1043: PA6 GF25 FR



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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The information provided in this documentation corresponds to knowledge of Radici Group High Performance Polymers on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience become available. The data provided reflects the average values of the properties measured over an adequate number of different production cycles and relates only to the designated material; this data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits nor used alone as the basis of design; it is not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Radici Group High Performance Polymers cannot anticipate all variations in actual end-use conditions Radici Group High Performance Polymers makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

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PROPERTY		STANDARD	UNIT	VALUE	
					DAM* Cond**
<i>PHYSICAL PROPERTIES</i>					
Density		ISO 1183	kg/m ³	1.38	
<i>MECHANICAL PROPERTIES</i>					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	9400	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	120	
Strain at Break	5mm/min	ISO 527-2/1A	%	2.9	
Flexural Modulus	2mm/min	ISO 178	MPa	9100	
Flexural Strength	2mm/min	ISO 178	MPa	190	
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	50	
Charpy Impact Strength	-30°C	ISO 179/1eU	kJ/m ²	7	
<i>THERMAL PROPERTIES</i>					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	217	
<i>FLAMMABILITY PROPERTIES</i>					
Flammability	0.8mm	UL 94	class	V-0	

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