

RENYCLE A GF3504K 3033 BK

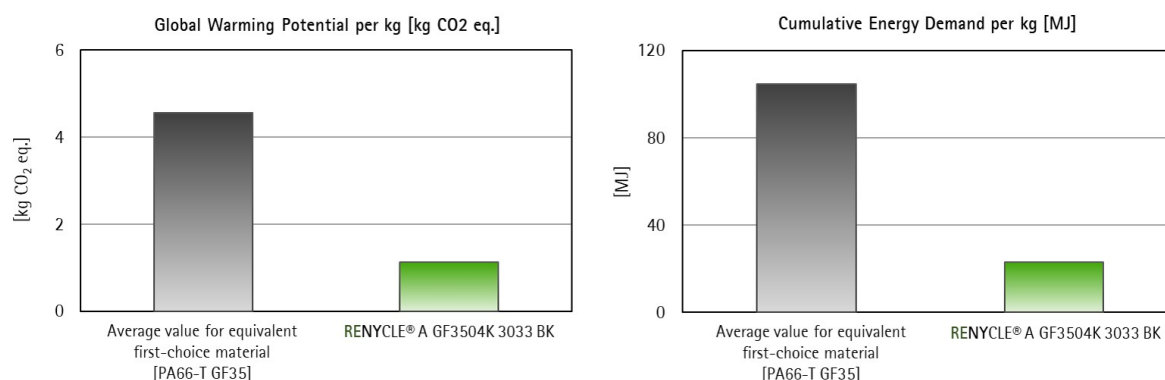
PRELIMINARY

DESCRIPTION

Recycled PA66 35% 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: PA66-T GF35



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: 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
280 - 300°C

Mold Temperature
80 - 100°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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IT

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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**
PHYSICAL PROPERTIES					
Density		ISO 1183	kg/m ³	1.4	
Melt Volume-Flow Rate	275/5 ^[1]	ISO 1133	cm ³ /10min	35	
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	11500	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	160	
Strain at Break	5mm/min	ISO 527-2/1A	%	2.2	
Flexural Modulus	2mm/min	ISO 178	MPa	10300	
Flexural Strength	2mm/min	ISO 178	MPa	260	
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	55	
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	7	
THERMAL PROPERTIES					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	260	
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	230	

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