

RENYCLE A T204K 3030 BK

DESCRIPTION

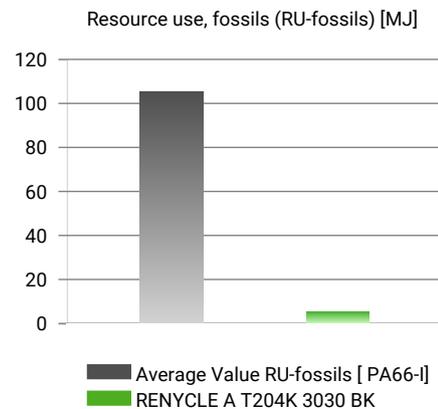
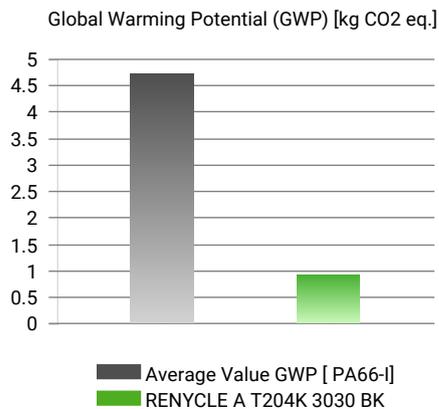
Recycled PA66, injection moulding grade. Toughened. Heat stabilized. Black colour.

The recycled material has been developed to reduce its environmental impact in comparison to traditional virgin options. Produced with selected feedstock coming from polymerization, yarn and compounding plants.

ISO 1043: PA66-I

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

ENVIRONMENTAL PERFORMANCE



The environmental performance metrics GWP and RU-fossils are defined per kg of material produced and are up to date as of the release date of the Technical Data Sheet.

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
270 - 290°C

Mold Temperature
70 - 80°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



RENYCLE A T204K 3030 BK

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density		kg/m ³	1110	
Moulding shrinkage - Parallel / Normal	290/70/60 ^[1]	ISO 1183 ISO 294-4	%	1.4 / 1.5
Water Absorption, immersion at 23°C	2mm	ISO 62	%	7.5
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	2.5
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2400
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	65
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	37
Flexural Modulus	2mm/min	ISO 178	MPa	2400
Flexural Strength	2mm/min	ISO 178	MPa	95
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	13
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m ²	7.5
THERMAL PROPERTIES				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	260
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	65
FLAMMABILITY PROPERTIES				
Automotive Interior Flammability	3mm	ISO 3795	mm/min	<30
ELECTRICAL PROPERTIES				
Volume Resistivity	500V	IEC 62631-3-1	Ohm*m	1E13
Surface Resistivity	500V	IEC 62631-3-2	Ohm	1E12

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

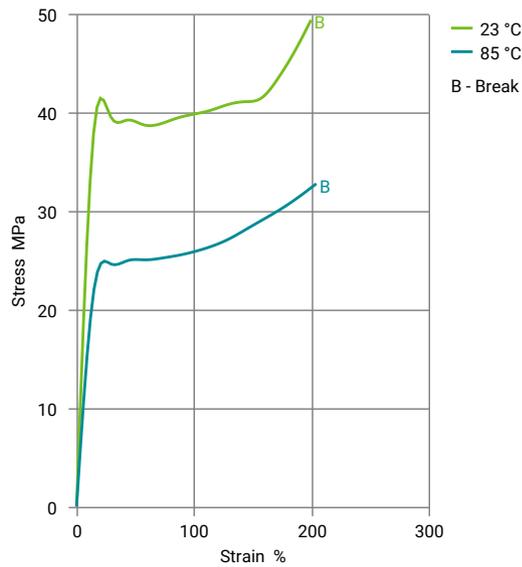
1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



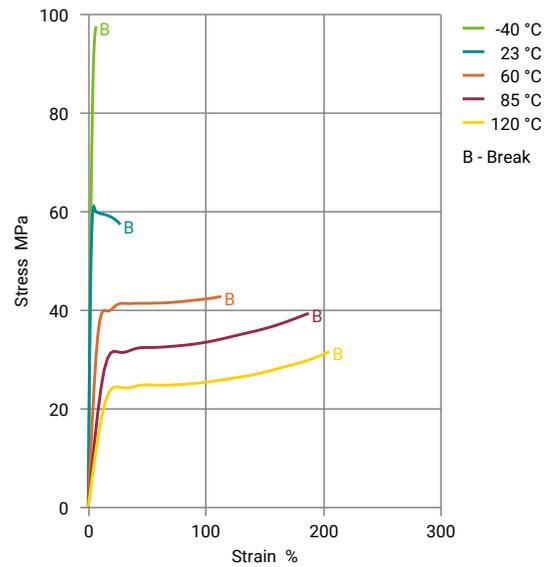
RENYCLE A T204K 3030 BK

DIAGRAMS

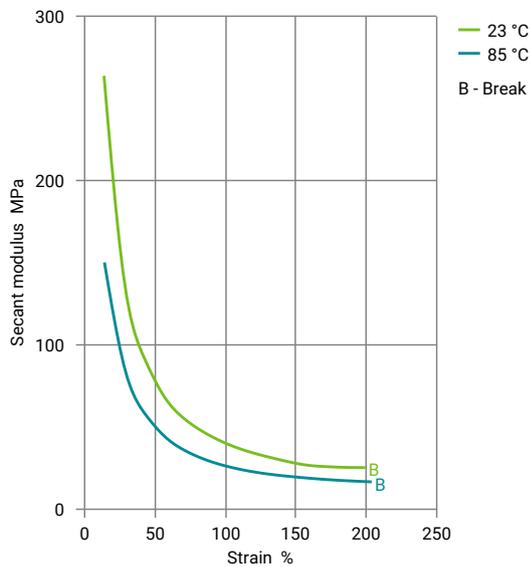
Stress-strain (cond.)



Stress-strain (dry)



Secant modulus-strain (cond.)



Secant modulus-strain (dry)

