

# RENYCLE S GFK3003K 3033 BK

PROVISIONAL

## DESCRIPTION

Recycled PA6, 30% glass-fibre and mineral-filler-reinforced injection moulding grade. Heat stabilized. Black colour.

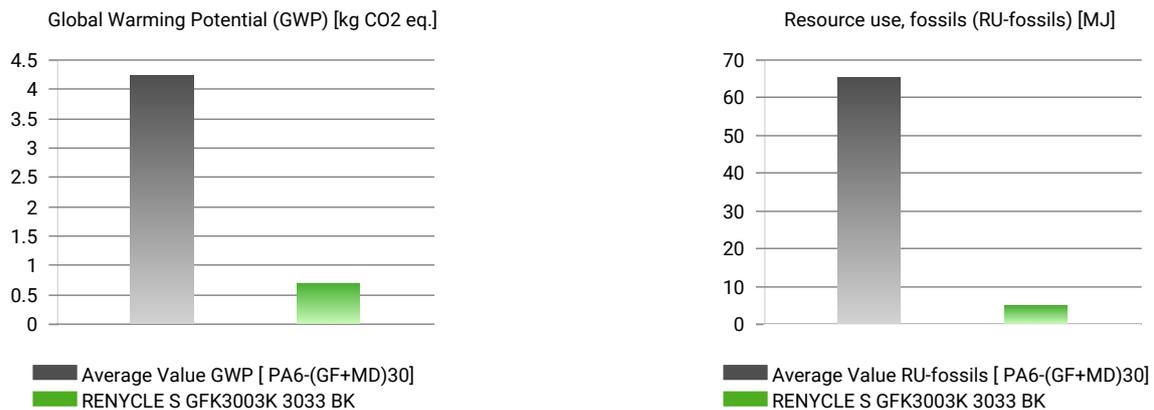
The recycled material has been developed to reduce its environmental impact in comparison to traditional virgin options. Suitable for parts requiring improved stiffness and dimensional stability.

ISO 1043: PA6-(GF+MD)30

REGIONAL AVAILABILITY: Europe

THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS

## 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. 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** |
| <b>PHYSICAL PROPERTIES</b>          |                |                   |       |        |
| Density                             | ISO 1183       | kg/m <sup>3</sup> | 1360  |        |
| Water Absorption, immersion at 23°C | ISO 62         | %                 |       | 7.5    |
| Moisture Absorption 23°C - 50%RH    | ISO 62         | %                 |       | 2      |
| <b>MECHANICAL PROPERTIES</b>        |                |                   |       |        |
| Tensile Modulus                     | ISO 527-2/1A   | MPa               | 6000  |        |
| Stress at Break                     | ISO 527-2/1A   | MPa               | 100   |        |
| Strain at Break                     | ISO 527-2/1A   | %                 | 4     |        |
| Flexural Modulus                    | ISO 178        | MPa               | 6000  |        |
| Flexural Strength                   | ISO 178        | MPa               | 180   |        |
| Charpy Impact Strength              | ISO 179/1eU    | kJ/m <sup>2</sup> | 47    |        |
| <b>THERMAL PROPERTIES</b>           |                |                   |       |        |
| Melting Temperature                 | ISO 11357-1/-3 | °C                | 220   |        |

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

