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v1.8

Technical Data Sheet

PCR PA6 Regranulate Green

Product Code: 000109

Recycled Content: 100 % PCR (post-consumer)

Melt Filtration: 150 µm

Product Description:

000109 PCR PA6 Regranulate Green comes from post-consumer recycled materials in Asia and is suitable for injection moulding and compounding applications. The material is GRS certified.

Physical Property	Value	Units	Test Standard	Test Condition
MFR	37	g/10 min.	ISO 1133	250°C, 2.16kg
Density	1.13	g/cm^3	ISO 1183	
Relative viscosity	2.5	n/a	ISO 307	0.01g/ml H_2SO_4, 96%
Viscosity Number	134	ml/g	ISO 307	0.005 g/ml H_2SO_4, 96%
Ash content	0.3	%	ISO 3451	825°C, 40 min.
Tensile strength	47	MPa	ISO 527	50mm/min.
Flexural strength	100	MPa	ISO 178	2mm/min.
Flexural modulus	2700	MPa	ISO 178	2mm/min.
Izod notched impact strength	4	kJ/m^2	ISO 180	

Typical Processing Conditions				
Processing Parameter	**Condition**	**Optimum**	**Range**	**Unit**
Melt temperature		250	245 - 275	°C
Barrel Zone temperature	Rear	245	240 - 270	°C

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Typical Processing Conditions				
Processing Parameter	**Condition**	**Optimum**	**Range**	**Unit**
Barrel Zone temperature	Center	255	250 - 280	°C
Barrel Zone temperature	Front	265	255 - 290	°C
Mold temperature		80	50 - 120	°C
Processing temperature upper limit		300		°C
Injection speed		slow to moderate		
Back pressure			0 - 1000	kPa
Pre-drying requirements			100 - 120°C, 4 - 6h	

Disclaimer

This information contained herein is based on the data available to us and is believed to be correct. However, Sinox makes no warranty, expressed or implied, regarding the accuracy of these data or the results to be obtained from the use thereof. Each user of the products shall convince himself through all available sources (including finished product testing in its appropriate environment) of the suitability of the products supplied for its particular purpose.

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