

Technical Data Sheet

PCR PA6 Regranulate Natural

Product Code: 000110

Recycled Content: 100 % PCR (post-consumer)

Melt Filtration: 150 µm

Product Description:

000110 PCR PA6 Regranulate Natural comes from post-consumer recycled materials in Asia and is suitable for compounding and injection moulding applications. The material is GRS certified.



Physical Property	Value	Units	Test Standard	Test Condition
MFR	33	g/10 min.	ISO 1133	250°C, 2.16kg
Density	1.12 - 1.13	g/cm ³	ISO 1183	23°C
Ash content	0.2	%	ISO 3451	825°C, 40 min.
Tensile strength	77	MPa	ISO 527	50mm/min.
Flexural strength	110	MPa	ISO 178	2mm/min.
Flexural modulus	2700	MPa	ISO 178	2mm/min.
Izod notched impact strength	5	kJ/m ²	ISO 180	23°C
Relative Viscosity	2.6		ISO 307	0.01 g/ml H ₂ SO ₄ , 96%
Viscosity number	140	ml/g	ISO 307	0.005 g/ml H ₂ SO ₄ , 96%

Typical Processing Conditions

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

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		

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