

Technical Data Sheet

PCR/ELV PA66 Regranulate Natural

Product Code: 000115

Recycled Content: 100 % PCR (post-consumer)

Melt Filtration: 125 µm

Product Description:

000115 PCR/ELV PA66 Regranulate Natural comes from post-consumer recycled and ELV 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
Tensile Strength	80	MPa	ISO 527-2	50mm/min
Tensile Strain at Break	14	%	ISO 527-2	50mm/min
Flexural Strength	123	MPa	ISO 178	2mm/min
Flexural Modulus	2900	MPa	ISO 178	2mm/min
Charpy Notched Impact Strength	5.3	kJ/m ²	ISO 179	23°C
Charpy Unnotched Impact Strength	69	kJ/m ²	ISO 179	23°C
Density	1.135	g/cm ³	ISO 1183-1	23°C
MFR	8.2	g/10min	ISO 1133-1	270°C, 0.325Kg
Fusing Point	260	°C	GB/T 28724-2012	DSC
Relative Viscosity	2.6	n/a	ISO 307	0.01g/ml H ₂ SO ₄ , 96%
Viscosity number	137.5	ml/g	ISO 307	0.005 g/ml, H ₂ SO ₄ , 96%
Relative Viscosity*	1.31	n/a	ISO 1628-1	0.0025 g/ml, H ₂ SO ₄ , 96%
Viscosity number*	122.1	ml/g	ISO 1628-1	0.0025 g/ml, H ₂ SO ₄ , 96%

* Values determined at 0.0025 g/ml, H₂SO₄, 96% per ISO 1628-1 are supplementary.

Typical Processing Conditions				
Processing Parameter	Condition	Optimum	Range	Unit
Melt Temp.		280	260 - 290	°C
Barrel Zone Temp.	Rear	260	250 - 265	°C
Barrel Zone Temp.	Center	270	265 - 275	°C
Barrel Zone Temp.	Front	275	270 - 280	°C
Mold Temp.		80	70 - 90	°C
Processing Temp. Upper Limit		300		°C
Injection Speed		Slow to Moderate		
Back Pressure		0 - 1000	0 - 1000	KPa
Pre-dry Requirements		90~110°C, 4~6hr		

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