

Technical Data Sheet

PCR PA6GF30 Recompound Natural

Product Code: 000118

Recycled Content: 50 % PCR (post-consumer)

Composition: 50 % PCR (post-consumer), 30 % virgin glass fibre, 20 % virgin polymer

Product Description:

000118 PCR PA6GF30 Recompound Natural comes from post-consumer recycled and virgin materials in Asia and is suitable for injection moulding applications. The material is GRS certified.



Physical Property	Value	Units	Test Standard	Test Condition
Tensile Strength	150	MPa	ISO 527-2	10mm/min
Tensile Strain at Break	3.0	%	ISO 527-2	10mm/min
Flexural Strength	220	MPa	ISO 178	2mm/min
Flexural Modulus	7600	MPa	ISO 178	2mm/min
Izod Notched Impact Strength	11	kJ/m ²	ISO 180	23°C
Temperature of Deflection Under Load	210	°C	ISO 75-2	0.45MPa
Temperature of Deflection Under Load	205	°C	ISO 75-2	1.80MPa
Volume Resistivity	1015	Ω·cm	IEC 60093	
Dielectric Strength	--	kV/mm	IEC 60243-1	
Density	1.36	g/cm ³	ISO 1183-1	
Ash	30	%	ISO 3451-1	
Moisture Absorption	1.8 - 2.3	%	ISO 62	Equilibrium, 23°C/50% r.h.

Physical Property	Value	Units	Test Standard	Test Condition
Molding Shrinkage	0.3 - 0.6	%	ISO 294-4	Flow
Molding Shrinkage	0.9 - 1.1	%	ISO 294-4	Transverse
Flammability	HB	/		UL 94

Typical Processing Conditions				
Processing Parameter	Condition	Optimum	Range	Unit
Melt Temp.		265	255 - 280	°C
Barrel Zone Temp.	Rear	240	230 - 250	°C
Barrel Zone Temp.	Center	255	250 - 270	°C
Barrel Zone Temp.	Front	265	260 - 280	°C
Mold Temp.		70	50 - 120	°C
Processing Temp. Upper Limit		290		°C
Injection Speed		Moderate to high		
Pre-dry Requirements		Dehumidifying dryer, 100 - 120°C, 4 - 6hr		

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