

Technical Data Sheet

PIR PA6 Regranulate Transparent

Product Code: 001603

Recycled Content: 100 % PIR (post-industrial)

Product Description:

001603 PIR PA6 Regranulate Transparent comes from post-industrial recycled materials in Asia and is suitable for injection moulding and compounding applications.



Physical Property	Value	Units	Test Standard	Test Condition
Density	1.136	g/cm ³	ISO 1183 / GB/T 1033	
Tensile Strength	58.7	MPa		Individual values: 59.9, 61.5, 54.7
Fracture Elongation	4.3	%	ISO 527-2 / GB/T 1040	Individual values: 4.1, 5.5, 3.4
Impact Strength (GB standard, Izod)	6.7 (average); individual values: 7.8, 7.4, 6.0, 5.8, 6.8	kJ/m ²	ISO 180/1A / GB/T 1843	8mm*4mm, 23°C
Impact Strength (ASTM standard, Izod)		kJ/m ²	ASTM D256	10.16mm*3.2mm, 23°C

Typical Processing Conditions				
Processing Parameter	Condition	Optimum	Range	Unit
Drying Temperature		120		°C
Drying Time		240		min
Injection Temperature	Zone 1	245		°C
Injection Temperature	Zone 2	240		°C

Typical Processing Conditions

Processing Parameter	Condition	Optimum	Range	Unit
Injection Temperature	Zone 3	235		°C
Injection Pressure	Stage 1	60		MPa
Injection Pressure	Stage 2	40		MPa

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