Technical Data Sheet

Circulen Recover EP PA6 GF20 H BLACK

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

20% glass fiber reinforced, heat stabilized Polyamide 6 formulated on mechanical recycled sourcing. The product is available in black color, pellet form.
Sustainability:
According with the requirements of Standard ISO 14021:2016, Circulen Recover EP PA6 GF20 H BLACK contains 55% of recycled material that is fully based on Post-Industrial Waste (PIW).

General

Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight	
Recycled Content	• Yes, 55%	
Features	• Heat Stabilized	• Medium Viscosity
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6 GF20	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.27 g/cm³	1.27 g/cm³	ISO 1183/A
Viscosity Number	145 cm³/g	145 cm³/g	ISO 307
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.02E+6 psi	7000 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	18900 psi	130 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.6 %	2.6 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°f (-30°c)	2.4 ft·lb/in²	5.0 kJ/m²	
73°f (23°c)	2.9 ft·lb/in²	6.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	19 ft·lb/in²	40 kJ/m²	
73°f (23°c)	21 ft·lb/in²	45 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	419 °F	215 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	392 °F	200 °C	ISO 75-2/Af

Additional Information

The tradename "Schulamid" may be abbreviated "SAM" in documents or on labels, "Recover" may be abbreviated "RC".

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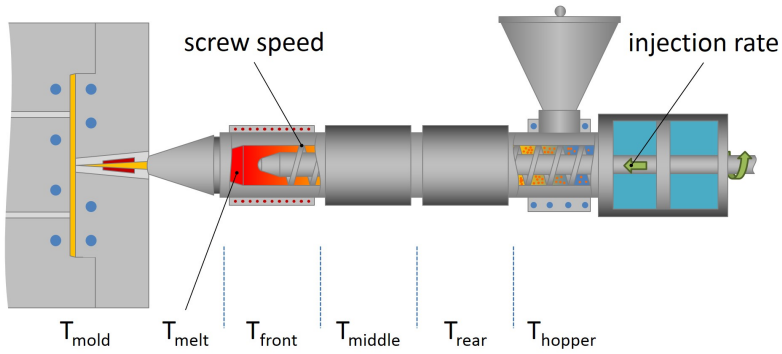

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

These are typical property values not to be construed as specification limits.