Technical Data Sheet

*Circulen*Recover EP PA66 GF30HIHBLK968001

Polyamide 66

Product Description

30% glass fiber reinforced, impact modified, heat stabilized Polyamide 66 formulated on mechanical recycled sourcing. Standard color is black, color matching for dark colors possible. Automotive structural applications are possible.Sustainability:According with the requirements of Standard ISO 14021:2016, Circulen Recover EP PA66 GF30 HI H BLACK contains 55% of recycled material that is fully based on pre-consumer waste.Recycled content according to DIN SPEC 91446:2021-12: R55Data Quality Level according to DIN SPEC 91446:2021-12: DQL4Data Quality Level according to VDA 284: DQL Automotive

Processing Method	Injection Molding
Attribute	Heat Stabilized; Impact Modified; Medium Viscosity
Filler/Reinforcement	Glass Fiber, 30%
Resin ID	PA66-I GF30

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.32	g/cm³	ISO 1183
Apparent (Bulk) Density	0.60 to 0.80	g/cm³	ISO 60
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	2.4	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	7.0	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	115	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	70.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	8300	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	4500	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	16	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	25	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	50	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	60	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	75	kJ/m²	ISO 179
Thermal			

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	250	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	230	°C	ISO 75-2/A
Flammable			
Burning Rate, (FMVSS 302)	<100	mm/min	FMVSS 302
Additional Information			
Water Absorption Sat/23C, - Conditioned	1.7	%	ISO 62
UL Information			
Flame Rating	HB		UL 94

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	60 to 120	°C