

Radilon® MIXLOY D 32CPA100 100 NT

 Radici Group High Performance Polymers - *Polyamide 610*
General Information
Product Description

PA610/ABS blend, high viscosity 10% mineral filled injection moulding grade. Partially bio-based. Natural colour.

Suitable for parts requiring good dimensional stability and low warpage. Improved impact resistance and very good property retention after moisture absorption.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Mineral, 10% Filler by Weight		
Additive	• Impact Modifier		
Features	• Good Dimensional Stability	• Impact Modified	• Renewable Resource Content
	• High Viscosity	• Low Warpage	
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• (PA610+ABS)-MD10		

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Water Absorption (Saturation, 73°F, 0.0787 in)	2.2	--	%	ISO 62
Water Absorption (Equilibrium, 73°F, 0.0787 in, 50% RH)	0.80	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	287000	247000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	6240	5800	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	16	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	30	85	%	ISO 527-2/1A/50
Flexural Modulus ²	281000	247000	psi	ISO 178
Flexural Stress ²	9430	7980	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	3.8	--	ft·lb/in ²	
73°F	4.8	5.7	ft·lb/in ²	
Charpy Unnotched Impact Strength (73°F)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature ³	428	--	°F	ISO 11357-3

Processing Information

Injection	Dry Unit
Drying Temperature - Desiccant Dryer	176 °F
Drying Time - Desiccant Dryer	2.0 to 4.0 hr
Dew Point - Desiccant Dryer	< -4 °F
Suggested Max Moisture	0.15 %
Processing (Melt) Temp	464 to 500 °F
Mold Temperature	104 to 140 °F
Injection Rate	Moderate

