



# RADILON D CF150W 333 BK

PROVISIONAL

## DESCRIPTION

PA610 15% carbon fibre reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts and components requiring high mechanical properties. The presence of carbon fibres also provides higher electrical and thermal conductivity. This grade is partially renewably-sourced (64% of base polymer by weight).

ISO 1043: PA610-CF15

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

*THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS*

Formerly Known As X6410

## MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

### Injection Molding Processing Parameters

Melt Temperature  
240 - 280°C

Mold Temperature  
80 - 90°C

Injection Speed  
high

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet  
ROHS compliant 2011/65/EU and following amendments



# RADILON D CF150W 333 BK

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>PHYSICAL PROPERTIES</b>				
Density	ISO 1183	kg/m <sup>3</sup>	1150	
Water Absorption, immersion at 23°C	ISO 62	%		2.7
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.2
<b>MECHANICAL PROPERTIES</b>				
Tensile Modulus	ISO 527-2/1A	MPa	11600	
Stress at Break	ISO 527-2/1A	MPa	180	
Strain at Break	ISO 527-2/1A	%	3.5	
Flexural Modulus	ISO 178	MPa	9400	
Flexural Strength	ISO 178	MPa	240	
Charpy Impact Strength	ISO 179/1eU	kJ/m <sup>2</sup>	50	
<b>THERMAL PROPERTIES</b>				
Melting Temperature	ISO 11357-1/-3	°C	220	
<b>FLAMMABILITY PROPERTIES</b>				
Flammability	UL 94	class	HB	
<b>ELECTRICAL PROPERTIES</b>				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1000	100
Surface Resistivity	IEC 62631-3-2	Ohm	100000	10000

\*: DAM = Dry As Moulded state according to ISO 16396-2, \*\*: Cond = Conditioned state similar to ISO 1110

