

RADILON D HSKC 106 NT

DESCRIPTION

PA610 injection moulding grade. Nucleated and lubricated, fast cycling. Heat stabilized. Natural colour.

This grade is partially renewably-sourced (64% of base polymer by weight).

ISO 1043: PA610

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

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
230 - 260°C

Mold Temperature
70 - 80°C

Injection Speed
medium

PRODUCT SAFETY AND APPROVALS

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



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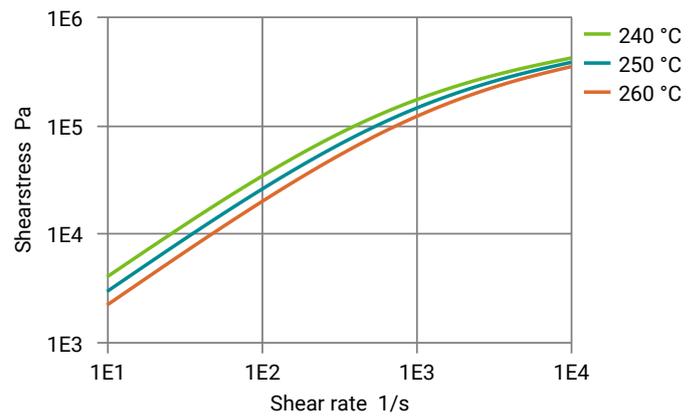
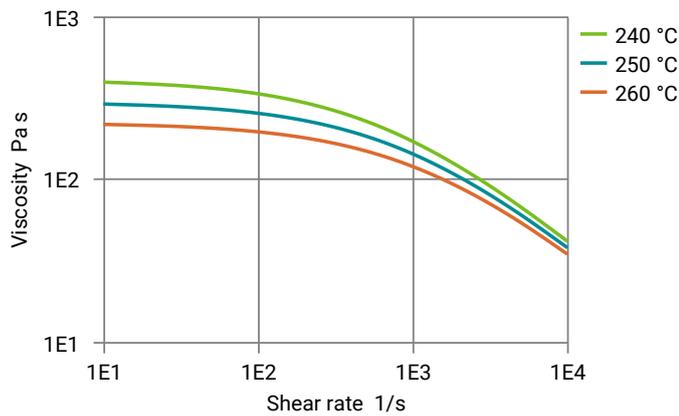
PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density	ISO 1183	kg/m ³	1080	
Moulding shrinkage - Parallel / Normal	ISO 294-4	%	1.0 / 1.2	
Water Absorption, immersion at 23°C	ISO 62	%	3.2	
Moisture Absorption 23°C - 50%RH	ISO 62	%	1.4	
Viscosity Index (Sulfuric Acid)	ISO 307	ml/g	142	
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	2600	
Stress at Yield	ISO 527-2/1A	MPa	70	
Yield Strain	ISO 527-2/1A	%	7	
Nominal Strain at Break	ISO 527-2/1A	%	40	
Flexural Modulus	ISO 178	MPa	2300	
Flexural Strength	ISO 178	MPa	90	
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	N	
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	4.5	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	220	
Heat Deflection Temperature	ISO 75/2Af	°C	55	
Vicat Softening Temperature	ISO 306	°C	185	
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class	HB	
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	1E11
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	1E10

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

1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



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DIAGRAMS
Viscosity-shear rate
Shearstress-shear rate

Specific volume-temperature (pvT)
