

RADILON MIXLOY D 32CPA100 100 NT

PROVISIONAL

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.

ISO 1043: (PA610+ABS)-MD10

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

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. 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 - 260°C

Mold Temperature
40 - 60°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	1130	
Water Absorption, immersion at 23°C	ISO 62	%		2.2
Moisture Absorption 23°C - 50%RH	ISO 62	%		0.8
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	1980	1700
Stress at Yield	ISO 527-2/1A	MPa	43	40
Yield Strain	ISO 527-2/1A	%	4.5	16
Nominal Strain at Break	ISO 527-2/1A	%	30	85
Flexural Modulus	ISO 178	MPa	1940	1700
Flexural Strength	ISO 178	MPa	65	55
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	N	N
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	10	12
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	8	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	220	

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

