

RADILON DT 40E50USR 333C BK

PROVISIONAL

DESCRIPTION

PA612 semi-rigid, high viscosity extrusion grade. Toughened. Improved resistance to uric acid solutions. Black colour.

Suitable for extrusion of profiles, tubes and pipes. Material especially developed for automotive under the hood applications, employed in selective catalytic reductions (SCR) systems.

ISO 1043: PA612-I

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 0.10%. Typical conditions with a desiccant drier: temperature 80 °C, dew point -20 °C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. 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

Extrusion Processing Parameters:

<i>Rear</i>	<i>Center Rear</i>	<i>Center Front</i>	<i>Front</i>	<i>Head and Die</i>	<i>Melt Temp</i>
220°C	250°C	260°C	270°C	275 - 280°C	275°C
428°F	482°F	500°F	518°F	527 - 536°F	527°F

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	1010	
Water Absorption, immersion at 23°C	ISO 62	%		2
Moisture Absorption 23°C - 50%RH	ISO 62	%		0.8
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	920	
Stress at Yield	ISO 527-2/1A	MPa	30	
Yield Strain	ISO 527-2/1A	%	25	
Nominal Strain at Break	ISO 527-2/1A	%	>100	
Flexural Modulus	ISO 178	MPa	800	
Flexural Strength	ISO 178	MPa	30	
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	85	
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	68	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	212	
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

