

RADILON MIXLOY S HSA20TUK 333 BK

PROVISIONAL

DESCRIPTION

PA6/ABS blend, injection moulding grade. Toughened and UV stabilized. Black colour.

Suitable for parts requiring high impact resistance and improved flexibility, intended to resist to light exposure. Low moisture absorption.

ISO 1043: (PA6+ABS)-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 0.15%. 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/m³	1060	
Moulding shrinkage - Parallel / Normal	260/60/60 [1]	ISO 294-4	%		0.8 / 0.9
Water Absorption, immersion at 23°C	2mm	ISO 62	%		5.8
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%		1.9
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	1800	900
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	45	30
Yield Strain	50mm/min	ISO 527-2/1A	%	3.7	20
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	>30	>100
Flexural Modulus	2mm/min	ISO 178	MPa	1700	910
Flexural Strength	2mm/min	ISO 178	MPa	60	33
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m²	N	N
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m²	60	105
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m²	15	
THERMAL PROPERTIES					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220	
Vicat Softening Temperature	50°C/h 50N	ISO 306	°C	113	

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

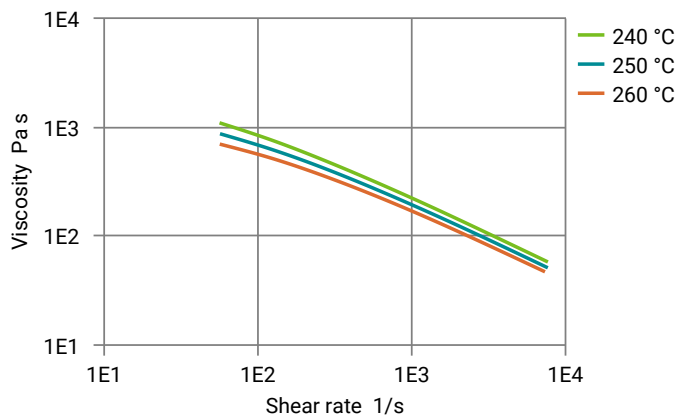
1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



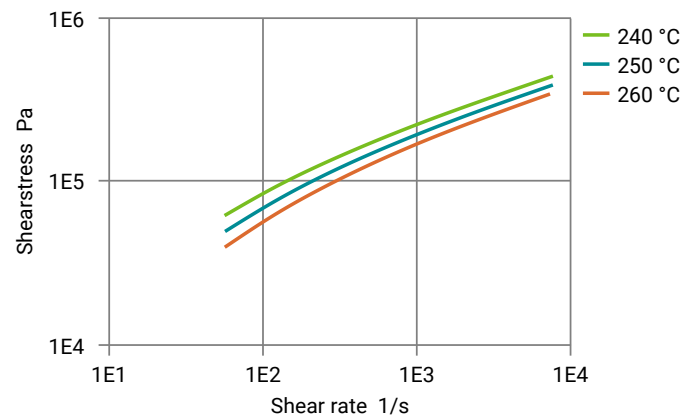
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DIAGRAMS

Viscosity-shear rate



Shearstress-shear rate



Specific volume-temperature (pvT)

