

# RADILON D 24D 1000 NT

## DESCRIPTION

PA610 low viscosity extrusion and injection moulding grade. Natural colour.

Suitable for parts which require higher fluidity for efficient processing. 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  
240 - 270°C

Mold Temperature  
60 - 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**
<b>PHYSICAL PROPERTIES</b>				
Density	ISO 1183	kg/m <sup>3</sup>	1070	
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		129
<b>MECHANICAL PROPERTIES</b>				
Tensile Modulus	ISO 527-2/1A	MPa	2000	
Stress at Yield	ISO 527-2/1A	MPa	57	
Yield Strain	ISO 527-2/1A	%	4.5	
Nominal Strain at Break	ISO 527-2/1A	%	>100	
Flexural Modulus	ISO 178	MPa	1900	
Flexural Strength	ISO 178	MPa	75	
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m <sup>2</sup>	5	
<b>THERMAL PROPERTIES</b>				
Melting Temperature	ISO 11357-1/-3	°C	221	
Heat Deflection Temperature	ISO 75/2Af	°C	55	
<b>FLAMMABILITY PROPERTIES</b>				
Flammability	UL 94	class	HB	
<b>ELECTRICAL PROPERTIES</b>				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	

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

