



RADILON D 40K 5138 OR

PRELIMINARY

DESCRIPTION

PA610 high viscosity extrusion grade. Heat stabilized. Orange colour.

Suitable for extrusion of rigid tubes and profiles. Designed for busbar coatings. 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

THE CHARACTERISTICS SHOWN HERE MUST BE CONSIDERED PRELIMINARY AND INDICATIVE FOR A PRODUCT AT DEVELOPMENTAL STAGE

Formerly Known As LX23016

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

Extrusion Temperature
240 - 290°C

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	1090	
Water Absorption, immersion at 23°C	ISO 62	%		3.2
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.4
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	2400	
Stress at Yield	ISO 527-2/1A	MPa	66	
Yield Strain	ISO 527-2/1A	%	4.4	
Nominal Strain at Break	ISO 527-2/1A	%	>20	
Flexural Modulus	ISO 178	MPa	2100	
Flexural Strength	ISO 178	MPa	85	
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	
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class	V-2	
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	
Comparative Tracking Index	IEC 60112	V	600	

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

