RADILON MIXLOY D RVA150 100 NT

PRELIMINARY

DESCRIPTION

PA610/ABS blend, 15% glass fibre injection moulding grade. Partially bio-based. Natural colour.

Suitable for parts requiring improved stiffness and very low moisture absorption. Excellent aesthetic surface aspect.

ISO 1043: (PA610+ABS)-GF15

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

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	Mold Temperature	Injection Speed
240 - 260°C	40 - 60°C	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*	VALUE Cond**
PHYSICAL PROPERTIES					
Density		ISO 1183	kg/m³	1150	
Water Absorption, immersion at 23°C	2mm	ISO 62	%	2.1	
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	0.8	
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	4750	4000
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	90	73
Yield Strain	50mm/min	ISO 527-2/1A	%	4	5
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	5	7.5
Flexural Modulus	2mm/min	ISO 178	MPa	4300	3500
Flexural Strength	2mm/min	ISO 178	MPa	140	110
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m²	67	65
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m²	11	
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m²	10	
THERMAL PROPERTIES					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220	

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