

RADILON MIXLOY S RVA80UK 333 BK

PRELIMINARY

DESCRIPTION

PA6/ABS blend, 8% glass fibre injection moulding grade. UV stabilized. Black colour.

Suitable for parts requiring improved stiffness and low moisture absorption. Excellent aesthetic surface aspect, intended to resist to light exposure.

ISO 1043: (PA6+ABS)-GF8

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
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/m ³	1160	
Melt Flow Rate	ISO 1133	g/10min		21
Moulding shrinkage - Parallel / Normal	ISO 294-4	%		0.4 / 0.6
Water Absorption, immersion at 23°C	ISO 62	%		5.7
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.8
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	4000	2600
Stress at Yield	ISO 527-2/1A	MPa	85	53
Yield Strain	ISO 527-2/1A	%	4.5	6.5
Nominal Strain at Break	ISO 527-2/1A	%	5	25
Flexural Modulus	ISO 178	MPa	3500	2350
Flexural Strength	ISO 178	MPa	120	85
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	45	85
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	4.5	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C		218
Heat Deflection Temperature	ISO 75/2Af	°C		108
Vicat Softening Temperature	ISO 306	°C		165

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

1: Temperature [°C] / Load [kg]

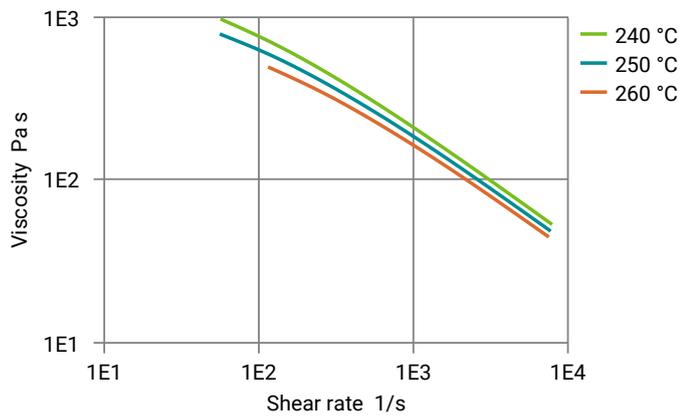
2: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



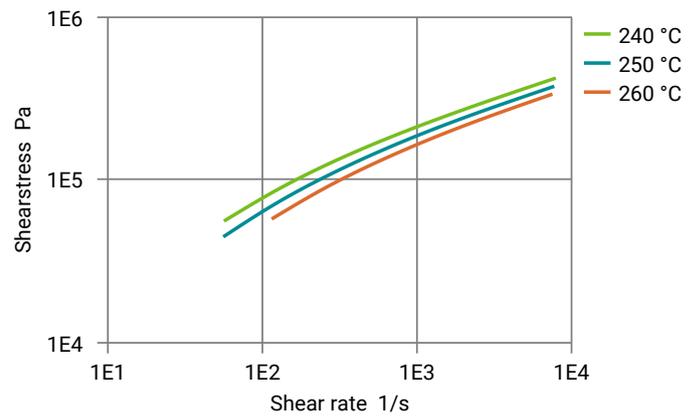
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DIAGRAMS

Viscosity-shear rate



Shearstress-shear rate



Specific volume-temperature (pvT)

