Radilon® D 24D 1000 NT

Radici Group High Performance Polymers - Polyamide 610

General Information

Product 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).

General

Features	• High Flow	• Low Viscosity	• Renewable Resource Content
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Processing Method	• Extrusion	• Injection Molding	
Resin ID (ISO 1043)	• PA610		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm³	ISO 1183
Water Absorption (Saturation, 73°F, 0.0787 in)	3.2	%	ISO 62
Water Absorption			ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	1.4	%	
Viscosity Number (H2SO4 (Sulphuric Acid))	129	cm³/g	ISO 307
Biobased Carbon Content	64	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	290000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	8270	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 100	%	ISO 527-2/1A/50
Flexural Modulus [2]	276000	psi	ISO 178
Flexural Stress [2]	10900	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	2.4	ft·lb/in²	ISO 179/1eA
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/Af
264 psi, Unannealed	131	°F	
Melting Temperature [3]	430	°F	ISO 11357-3
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity (500 V)	1.0E+12	ohms	IEC 62631-3-2
Volume Resistivity (500 V)	1.0E+13	ohms·m	IEC 62631-3-1
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.031 in)	HB		UL 94

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Processing Information		
Injection	**Nominal Value**	**Unit**
Drying Temperature - Desiccant Dryer	176	°F
Drying Time - Desiccant Dryer	2.0 to 4.0	hr
Dew Point - Desiccant Dryer	< -4	°F
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	464 to 518	°F
Mold Temperature	140 to 176	°F
Injection Rate	Moderate	

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 0.079 in/min

[3] 10°C/min