

Radilon® MIXLOY D CPA100K 100 NT

Radici Group High Performance Polymers - Polyamide 610

General Information

Product Description

PA610/ABS blend, 10% mineral filled injection moulding grade. Heat stabilized. Partially bio-based. Natural colour.

Suitable for parts requiring good dimensional stability and low warpage. Improved impact resistance and very good property retention after moisture absorption.

General

Filler / Reinforcement	• Mineral, 10% Filler by Weight
Additive	• Heat Stabilizer
Features	• Good Dimensional Stability • Heat Stabilized • Good Impact Resistance • Low Warpage • Renewable Resource Content
Agency Ratings	• EU 2011/65/EC
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• (PA610+ABS)-MD10

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.12	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	2.3	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	0.80	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	319000	232000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	6530	5800	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	25	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	60	80	%	ISO 527-2/1A/50
Flexural Modulus ²	319000	261000	psi	ISO 178
Flexural Stress ²	10200	7980	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	3.8	--	ft·lb/in ²	
73°F	5.2	7.6	ft·lb/in ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
73°F	No Break	No Break		
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature ³	433	--	°F	ISO 11357-3

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Injection	Dry	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	0.15	%
Processing (Melt) Temp	464 to 500	°F
Mold Temperature	104 to 140	°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