

# Radilon® MIXLOY D 32CPA100 100 NT

## Radici Group High Performance Polymers - Polyamide 610

### General Information

#### Product Description

PA610/ABS blend, high viscosity 10% mineral filled injection moulding grade. 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	• Impact Modifier
Features	• Good Dimensional Stability • Impact Modified • High Viscosity • 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 <sup>1</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm <sup>3</sup>	ISO 1183
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	2.2	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	0.80	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	287000	247000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	6240	5800	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	16	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	30	85	%	ISO 527-2/1A/50
Flexural Modulus <sup>2</sup>	281000	247000	psi	ISO 178
Flexural Stress <sup>2</sup>	9430	7980	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	3.8	--	ft·lb/in <sup>2</sup>	
73°F	4.8	5.7	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength				ISO 179/1eU
73°F	No Break	No Break		
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature <sup>3</sup>	428	--	°F	ISO 11357-3

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**Processing Information**

<b>Injection</b>	<b>Dry</b>	<b>Unit</b>
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**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 0.079 in/min

<sup>3</sup> 10°C/min