

RADILON D RV600RKC 306 NER 6208

Material code Colour code

PROVISIONAL

DESCRIPTION

PA610 60% glass fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring very high stiffness and good mechanical resistance. Used in drinking water applications.

This grade is partially renewably-sourced (60% of base polymer by weight).

ISO 1043 : PA610-T GF60

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. 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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
240 ÷ 280 °C	80 ÷ 90 °C	Medium-High

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2011/65/UE and following amendments

Material grade suitable to be in contact with drinking water according to the KTW and DVGW-Standard W270

Material grade suitable to be in contact with drinking water according to ACS DGS/SD7A n°571 Nov 25, 2002

Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE	
				DAM*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m ³	1670	
Moulding shrinkage – Parallel / Normal	//***	ISO 294-4	%	0,2 / 0,3	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	0,5	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	1,3	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	20200	17600
Stress at Break	5mm/min	ISO 527-2/1A	MPa	245	205
Strain at Break	5mm/min	ISO 527-2/1A	%	2,6	2,9
Flexural Modulus	2mm/min	ISO 178	MPa	18000	15650
Flexural Strength	2mm/min	ISO 178	MPa	380	320
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	100	103
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	17	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	217	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	215	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	215	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]