

# RADILON D EP25ZK 100 NAT 5524

Material code      Colour code

PROVISIONAL

## DESCRIPTION

PA610 extrusion grade with high flexibility. Toughened and plasticized. Heat stabilized. Natural colour.

Suitable for extrusion of pipes, profiles and cable jackets. It offers improved impact resistance, also at low temperatures.

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

ISO 1043 : PA610-HI-P

## 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:	Extrusion Temp: 230 ÷ 250 °C
230 ÷ 260 °C	70 ÷ 80 °C	Medium	

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2002/95/CE and following amendments

Issued: 18/07/2011

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## Technical data sheet

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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>Physical Properties</b>				
Density	ISO 1183	Kg/m <sup>3</sup>	1025	
Moisture absorption 23°C – 50%RH	2mm thk ISO 62	%	0,9	
Water absorption, immersion at 23°C	2mm thk ISO 62	%	2	
<b>Mechanical Properties</b>				
Tensile Modulus	1mm/min ISO 527-2/1A	MPa	500	320
Stress at Yield	50mm/min ISO 527-2/1A	MPa	25	20
Nominal Strain at Break	50mm/min ISO 527-2/1A	%	>100	>100
Flexural Modulus	2mm/min ISO 178	MPa	375	
Flexural Strength	2mm/min ISO 178	MPa	17	
Charpy Notched Impact Strength	+23°C ISO 179/1 eA	KJ/m <sup>2</sup>	95	125
Charpy Notched Impact Strength	-30°C ISO 179/1 eA	KJ/m <sup>2</sup>	75	
<b>Thermal Properties</b>				
Melting Temperature	10°C/min ISO 11357-1-3	°C	215	
Heat Deflection Temperature	1.8 MPa ISO 75/2 A f	°C	50	
Heat Deflection Temperature	0.45 MPa ISO 75/2 B f	°C	100	

\*DAM = Dry As Moulded state    \*\*Cond = Conditioned state similar to ISO 1110

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