

RADILON D E50ZW 333 NER 6463

Material code

Colour code

PROVISIONAL

DESCRIPTION

PA610 flexible extrusion grade. Toughened and heat stabilized. Good resistance to Zinc Chloride solution. Black colour.

Suitable for extrusion of pipes, profiles and cable jackets.

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

ISO 1043 : PA610-HI

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

Technical data sheet

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| PROPERTY | | STANDARD | UNIT | VALUE | |
|-------------------------------------|----------|-----------------|-------------------|-------|--------|
| | | | | DAM* | Cond** |
| Physical Properties | | | | | |
| Density | | ISO 1183 | Kg/m ³ | 1010 | |
| Moisture absorption 23°C – 50%RH | 2mm thk | ISO 62 | % | 0.9 | |
| Water absorption, immersion at 23°C | 2mm thk | ISO 62 | % | 2.2 | |
| Mechanical Properties | | | | | |
| Tensile Modulus | 1mm/min | ISO 527-2/1A | MPa | 1100 | 700 |
| Stress at Yield | 50mm/min | ISO 527-2/1A | MPa | 30 | 23 |
| Yield Strain | 50mm/min | ISO 527-2/1A | % | 7,5 | >50 |
| Nominal Strain at Break | 50mm/min | ISO 527-2/1A | % | >50 | >100 |
| Flexural Modulus | 2mm/min | ISO 178 | MPa | 950 | |
| Flexural Strength | 2mm/min | ISO 178 | MPa | 30 | |
| Charpy Notched Impact Strength | +23°C | ISO 179/1 eA | KJ/m ² | 75 | 85 |
| Thermal Properties | | | | | |
| Melting Temperature | 10°C/min | ISO 11357-1-3 | °C | 220 | |
| Heat Deflection Temperature | 1.8 MPa | ISO 75/2 A f | °C | 50 | |
| Vicat Softening Temperature | 50°C/h | ISO 306/B50 50N | °C | 125 | |

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

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