

PRODUCT INFORMATION

RADILON D CF150W 333 BK

PROVISIONAL

DESCRIPTION

PA610 15% carbon fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts and components requiring high mechanical properties. The presence of carbon fibers also provides higher electrical and thermal conductivity. This grade is partially renewably-sourced (60% of base polymer by weight).

ISO 1043: PA610 CF15

Formerly known as X6410.

THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

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.

Injection Molding Processing Parameters

Melt Temperature
240 - 280°C

Mold Temperature
80 - 90°C

Injection Speed
high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet
ROHS compliant 2011/65/UE and following amendments

TECHNICAL DATA SHEET

RADILON D CF150W 333 BK

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density	ISO 1183	kg/m ³	1150	
Water Absorption, immersion at 23°C	2mm ISO 62	%	2.7	
Moisture Absorption 23°C - 50%RH	2mm ISO 62	%	1.2	
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min ISO 527-2/1A	MPa	11600	
Stress at Break	5mm/min ISO 527-2/1A	MPa	180	
Strain at Break	5mm/min ISO 527-2/1A	%	4	
Flexural Modulus	2mm/min ISO 178	MPa	9500	
Flexural Strength	2mm/min ISO 178	MPa	245	
Charpy Impact Strength	+23°C ISO 179/1eU	kJ/m ²	65	
THERMAL PROPERTIES				
Melting Temperature	10°C/min ISO 11357-1/-3	°C	217	
FLAMMABILITY PROPERTIES				
Flammability	0.8mm UL 94	class	HB	
ELECTRICAL PROPERTIES				
Volume Resistivity	500V IEC 60093	Ohm*m	1000	100
Surface Resistivity	500V IEC 60093	Ohm	100000	10000

*: DAM = Dry As Moulded state according to ISO 16396-2 **: Cond = Conditioned state similar to ISO 1110