

RADILON D 40EP25ZW 7037 BLU 6556

Material code Colour code

PROVISIONAL

DESCRIPTION

PA610 flexible, high viscosity extrusion grade. Toughened and plasticized. Heat stabilized. Blue colour.

Suitable for extrusion of pipes, profiles and cable jackets. Good 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: 20/12/2012

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The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience become available. The data provided reflects the average values of the properties measured over an adequate number of different production cycles and relates only to the designated material; this data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits nor used alone as the basis of design; it is not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Radici Plastics cannot anticipate all variations in actual end-use conditions Radici Plastics makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

Technical data sheet

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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
Physical Properties				
Density	ISO 1183	Kg/m ³	1040	
Moisture absorption 23°C – 50%RH	2mm thk ISO 62	%	0,9	
Water absorption, immersion at 23°C	2mm thk ISO 62	%	2	
Mechanical Properties				
Tensile Modulus	1mm/min ISO 527-2/1A	MPa	510	350
Stress at 100% strain	50mm/min ISO 527-2/1A	MPa	28	23
Stress at Break	5mm/min ISO 527-2/1A	MPa	36	33
Nominal Strain at Break	50mm/min ISO 527-2/1A	%	300	330
Flexural Modulus	2mm/min ISO 178	MPa	450	300
Flexural Strength	2mm/min ISO 178	MPa	17	13
Charpy Notched Impact Strength	+23°C ISO 179/1 eA	KJ/m ²	95	110
Charpy Notched Impact Strength	-30°C ISO 179/1 eA	KJ/m ²	55	
Thermal Properties				
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	
Electrical Properties				
Volume resistivity	500V IEC 60093	ohm · m	1 E+13	1 E+11
Surface resistivity	500V IEC 60093	ohm	1 E+12	1 E+10

The characteristics shown here must be considered purely provisional and indicative for a product at developmental stage.

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