

RADILON D 40EP25ZW 100 NAT 6444

Material code

Colour code

PROVISIONAL

DESCRIPTION

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





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	550	
Stress at 100% strain	50mm/min	ISO 527-2/1A	MPa	30	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	36	
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	>100	
Flexural Modulus	2mm/min	ISO 178	MPa	520	
Flexural Strength	2mm/min	ISO 178	MPa	18	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	95	
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²		
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

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

