Product Information

RADILON D CF150W 333 NER 6410

Material code *Colour code*

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

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. 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:
240 ÷ 280 °C	80 ÷ 90 °C	High

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*	VALUE Cond**
Physical Properties					
Density		ISO 1183	Kg/m^3	1150	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	1.2	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	2.7	
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 179/1 eU	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	1 E+3	1 E+2
Surface resistivity	500V	IEC 60093	ohm	1 E+5	1 E+4

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