

RADILON D E35ZW 333 NER 6395

Material code

Colour code

PROVISIONAL

DESCRIPTION

PA610 extrusion grade with high flexibility. 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-T

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	1000	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	0.8	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	1.9	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	750	
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	23	
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	85	
Flexural Modulus	2mm/min	ISO 178	MPa	770	
Flexural Strength	2mm/min	ISO 178	MPa	23	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	80	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	220	

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

