

RADILON MIXLOY S 32HSA20K 100 NT

(PA6+ABS)

RadiciGroup High Performance Polymers

Product Texts

PA6/ABS blend, medium viscosity extrusion grade. Heat stabilized. Natural colour.

Suitable for parts requiring low moisture absorption and high dimensional stability. Also apt for 3D printing

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2500 / -	MPa	ISO 527
^[C] Yield stress	60 / -	MPa	ISO 527
^[C] Yield strain	4 / -	%	ISO 527
^[C] Nominal strain at break	>50 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	9 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
^[C] Vicat softening temperature, B	130 / *	°C	ISO 306

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	6.4 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2 / *	%	Sim. to ISO 62
^[C] Density	1090 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Profile Extrusion, Other Extrusion, Additive Manufacturing

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Granules, Natural Color

Regional Availability

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

Additives

Lubricants, Release agent

Other text information

Injection molding

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.

Extrusion Processing Parameter:

Rear	Center Rear	Center Front	Front	Head and Die	Melt Temp
260°C	260°C	265°C	270°C	275°C	275°C
500°F	500°F	510°F	520°F	527°F	527°F