RADILON MIXLOY S CPA100K 100 NT

(PA6+ABS)-MD10 RadiciGroup High Performance Polymers

Product Texts

PA6/ABS blend, 10% mineral filled injection moulding grade. Heat stabilized. Natural colour.

Suitable for parts requiring good dimensional stability and low warpage. Improved impact resistance and good property retention after moisture absorption.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**2800 / 1300**	MPa	ISO 527
[C] Yield stress	**55 / 35**	MPa	ISO 527
[C] Yield strain	**3 / 15**	%	ISO 527
[C] Nominal strain at break	**45 / >50**	%	ISO 527
[C] Charpy impact strength, +23°C	**N / N**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**10 / 18**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**9 / -**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**222 / ***	°C	ISO 11357-1/-3
[C] Vicat softening temperature, B	**135 / ***	°C	ISO 306

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**5.5 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**1.7 / ***	%	Sim. to ISO 62
[C] Density	**1140 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Processing humidity	**≤0.15**	%	-
Melt temperature	**240 - 280**	°C	-
Mold temperature	**40 - 60**	°C	-

Characteristics

Processing
Injection Molding

Delivery form
Granules, Natural Color

Additives
Release agent

Special Characteristics
High impact or impact modified, Heat stabilized or stable to heat

Features
Low Warpage

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

Other text information

Injection molding
The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. 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.

Injection Molding Processing Parameters

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Melt Temperature	Mold Temperature	Injection Speed
240 - 280°C	40 - 60°C	medium

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