

Product Texts

PA610 injection moulding grade. Nucleated and lubricated, fast cycling. Improved UV resistance. Deep black colour.

Suitable for parts requiring high productivity, intended to resist to light exposure. This grade is partially renewably-sourced (64% of base polymer by weight).

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	1.0 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.2 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2400 / -	MPa	ISO 527
^[C] Yield stress	65 / -	MPa	ISO 527
^[C] Yield strain	4.5 / -	%	ISO 527
^[C] Nominal strain at break	40 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	5 / -	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] Temp. of deflection under load, 1.80 MPa	65 / *	°C	ISO 75-1/-2
^[C] Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	1E13 / 1E11	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	* / 1E10	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	3.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.4 / *	%	Sim. to ISO 62
^[C] Density	1080 / -	kg/m ³	ISO 1183
Biobased content	64	%	-

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Features

Nucleated

Delivery form

Granules, Black

Certifications

Contains renewable resources

Additives

Lubricants, Release agent

Regional Availability

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

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

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.

Injection Molding Processing Parameters

Melt Temperature

230 - 260°C

Mold Temperature

70 - 80°C

Injection Speed

medium