

Product Texts

PA610/ABS blend, injection moulding grade. UV stabilized. Deep black colour.

Suitable for parts requiring superior dimensional stability, intended to resist to light exposure. Low water absorption and excellent aesthetic surface aspect.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	2400 / 2100	MPa	ISO 527
[C] Yield stress	60 / 50	MPa	ISO 527
[C] Yield strain	4 / 4	%	ISO 527
[C] Nominal strain at break	25 / 40	%	ISO 527
[C] Charpy impact strength, +23°C	70 / -	kJ/m ²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	4 / 4	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	221 / *	°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	2.5 / *	%	Sim. to ISO 62
[C] Humidity absorption	0.9 / *	%	Sim. to ISO 62
[C] Density	1080 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Delivery form

Granules, Black

Additives

Release agent

Special Characteristics

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

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

Melt Temperature	Mold Temperature	Injection Speed
240 - 260°C	40 - 60°C	medium