

Product Texts

PA610/ABS blend, high viscosity 10% mineral filled injection moulding grade. Natural colour.

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

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	1980 / 1700	MPa	ISO 527
^[C] Yield stress	43 / 40	MPa	ISO 527
^[C] Yield strain	4.5 / 16	%	ISO 527
^[C] Nominal strain at break	30 / >50	%	ISO 527
^[C] Charpy impact strength, +23°C	N / N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	10 / 12	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	8 / -	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]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	2.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	0.8 / *	%	Sim. to ISO 62
^[C] Density	1130 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Granules, Natural Color

Features

Low Warpage

Additives

Release agent

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
240 - 260°C

Mold Temperature
40 - 60°C

Injection Speed
medium