

**Product Texts**

PA610/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 very good property retention after moisture absorption.

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>2200 / 1600</b>	MPa	ISO 527
<sup>[C]</sup> Yield stress	<b>45 / 40</b>	MPa	ISO 527
<sup>[C]</sup> Yield strain	<b>4 / 25</b>	%	ISO 527
<sup>[C]</sup> Nominal strain at break	<b>&gt;50 / &gt;50</b>	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>N / N</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	<b>11 / 16</b>	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	<b>8 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>223 / *</b>	°C	ISO 11357-1/-3

[C]: CAMPUS

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<sup>[C]</sup> Water absorption	<b>2.3 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>0.8 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1120 / -</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**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**

Melt Temperature  
240 - 260°C

Mold Temperature  
40 - 60°C

Injection Speed  
medium