RADILON DT 22D 1000 NT

PA612 RadiciGroup High Performance Polymers

Product Texts

PA612 low viscosity. Natural colour.

Suitable for extrusion processes where low viscosity is required, typically monofilament extrusion. Suitable also for injection and rotational moulding operations.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**2300 / -**	MPa	ISO 527
[C] Yield stress	**60 / -**	MPa	ISO 527
[C] Yield strain	**7 / -**	%	ISO 527
[C] Charpy impact strength, +23°C	**N / -**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**4.5 / -**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**215 / ***	°C	ISO 11357-1/-3
[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 / -**	Ohm*m	IEC 62631-3-1

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**3 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**1.2 / ***	%	Sim. to ISO 62
[C] Density	**1060 / -**	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	**≤0.1**	%	-
Melt temperature	**230 - 260**	°C	-
Mold temperature	**70 - 80**	°C	-

Characteristics

Processing

Injection Molding, Profile Extrusion, Other Extrusion, Rotational Molding

Delivery form

Granules, Natural Color

Applications

Monofilament

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 0.10%. 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	Mold Temperature	Injection Speed
230 - 260°C	70 - 80°C	medium

Extrusion Temperature
240 - 290°C