

RADILON A RCW4015W 333BK

*Material code**Colour code*

PROVISIONAL

DESCRIPTION

PA66 40% glass fiber and mineral reinforced injection molding grade, black color.

Suitable for parts requiring high stiffness and good dimensional stability .

ISO 1043 : PA66-MG40

MATERIAL HANDLING AND PROCESSING

This product is delivered in moisture-proof packaging ready for injection molding process. Maximum recommended moisture content for best processing is 0.15%. Typical conditions using a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more.

Avoid excessive shear rates and high thermal stresses for better processing. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Color variation and mechanical properties reduction may occur and should always be carefully monitored.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
275 ÷ 300 °C	80 ÷ 100 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet (SDS)

Formerly known as N66MG40HSL.BK

RoHS compliant 2011/65/UE and following amendments





Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE	
				DAM*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m ³	1500	
Moulding shrinkage - Parallel / Normal	//***	ISO 294-4	%	0.34 / 0.2	
Viscosity Index (Sulfuric Acid)		ISO 307	ml/g	142	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	8400	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	127	
Strain at Break	5mm/min	ISO 527-2/1A	%	2.8	
Flexural Modulus	2mm/min	ISO 178	MPa	8100	
Flexural Strength	2mm/min	ISO 178	MPa	197	
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	42	
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	40	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	4.5	
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	4.5	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	260	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	225	
Flammability Properties					
Automotive interior flammability	Burn rate	FMVSS302	mm/min	20.3	

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]

