

RADILON A RV250KB 856 BRU

*Material code**Colour code*

DESCRIPTION

PA66 25% glass fiber reinforced injection moulding grade. Heat stabilized. Natural brown colour.

Suitable for parts requiring medium stiffness, intended for use in contact with oil and grease at high temperature.

ISO 1043 : PA66-T GF25

MATERIAL HANDLING AND PROCESSING

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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
280 ÷ 300 °C	80 ÷ 100 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2002/95/CE and following amendments



Technical data sheet

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PROPERTY	UNIT	STANDARD	VALUE	
			DAM*	Cond**
Physical Properties				
Density		ISO 1183	Kg/m ³	1320
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	2
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	7.4
Viscosity Index (Sulfuric Acid)		ISO 307	ml/g	130
Mechanical Properties				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	8500 5800
Stress at Break	5mm/min	ISO 527-2/1A	MPa	165 115
Strain at Break	5mm/min	ISO 527-2/1A	%	3.3 6
Flexural Modulus	2mm/min	ISO 178	MPa	7000 4200
Flexural Strength	2mm/min	ISO 178	MPa	240 155
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	60 80
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	55
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	11 13
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	9
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
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	250
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	250
Flammability Properties				
Flammability	0.8mm	UL 94	class	HB
Glow Wire Flammability Index	1mm / 2mm	IEC 60695-2-1/2	°C/mm	700 / 675
Glow Wire Ignition Temperature	1mm / 2mm	IEC 60695-2-1/3	°C/mm	725 / 700
Automotive interior flammability	Burn rate	FMVSS302	mm/min	0
Electrical Properties				
Volume resistivity	500V	IEC 60093	ohm · m	1 E+13 1 E+11
Surface resistivity	500V	IEC 60093	ohm	1 E+12 1 E+10
Comparative Tracking Index	Sol.A	IEC 60112	V	600

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

