

RADILON A RV250 333 NER

Material code Colour code

DESCRIPTION

PA66 25% glass fiber reinforced injection moulding grade. Black colour.

Suitable for parts requiring medium stiffness and good mechanical resistance.

ISO 1043 : PA66 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 | | STANDARD | UNIT | VALUE | |
|-------------------------------------|-----------|-----------------|-------------------|--------|--------|
| | | | | DAM* | Cond** |
| Physical Properties | | | | | |
| Density | | ISO 1183 | Kg/m ³ | 1300 | |
| Moisture absorption 23°C – 50%RH | 2mm thk | ISO 62 | % | 2 | |
| Water absorption, immersion at 23°C | 2mm thk | ISO 62 | % | 7.4 | |
| Mechanical Properties | | | | | |
| Tensile Modulus | 1mm/min | ISO 527-2/1A | MPa | 8500 | 6500 |
| Stress at Break | 5mm/min | ISO 527-2/1A | MPa | 155 | 105 |
| Strain at Break | 5mm/min | ISO 527-2/1A | % | 3 | 3.5 |
| Flexural Modulus | 2mm/min | ISO 178 | MPa | 7650 | |
| Flexural Strength | 2mm/min | ISO 178 | MPa | 240 | |
| Charpy Impact Strength | +23°C | ISO 179/1 eU | KJ/m ² | 55 | 70 |
| Charpy Impact Strength | -30°C | ISO 179/1 eU | KJ/m ² | 45 | |
| Charpy Notched Impact Strength | +23°C | ISO 179/1 eA | KJ/m ² | 10 | 15 |
| Charpy Notched Impact Strength | -30°C | ISO 179/1 eA | KJ/m ² | 8 | |
| 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 | 240 | |
| Flammability Properties | | | | | |
| Flammability | 0.8mm | UL 94 | class | HB | |
| Glow Wire Flammability Index | 2mm | IEC 60695-2-1/2 | °C/mm | 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 | 500 | |

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

