

RADILON D RV300W 333 NER 6409

Material code

Colour code

PROVISIONAL

DESCRIPTION

PA610, 30% glass fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring good dimensional stability, high stiffness and mechanical resistance. Typical application: automotive fuel system components.

This grade is partially renewably-sourced (60% of base polymer by weight).

ISO 1043 : PA610-T- GF30

MATERIAL HANDLING AND PROCESSING

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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
240 ÷ 260 °C	80 ÷ 90 °C	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	1300
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	1
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	2.2
Mechanical Properties				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	8700
Stress at Break	5mm/min	ISO 527-2/1A	MPa	145
Strain at Break	5mm/min	ISO 527-2/1A	%	3,8
Flexural Modulus	2mm/min	ISO 178	MPa	7500
Flexural Strength	2mm/min	ISO 178	MPa	220
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	80
Thermal Properties				
Melting Temperature	10°C/min	ISO 11357-1-3	°C	217
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	200
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	215
Flammability Properties				
Flammability	0.8mm	UL 94	class	HB

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

