Product Information

RADILON S BMX200K 333 NER

Material code *Colour code*

DESCRIPTION

PA6 high viscosity blow moulding grade. Toughened, heat stabilized. Black colour.

Suitable for blow-moulding of tubes and containers; typically used for automotive air ducts.

ISO 1043 : PA6-HIT

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:	Extrusion Temp: 250 ÷ 280 °C
250 ÷ 280 °C	70 ÷ 80 °C	Medium	

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*	VALUE Cond**
Physical Properties					
Density		ISO 1183	Kg/m^3	1070	
Melt Flow Index	275°C / 5kg	ISO 1133	g/10'	3	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	1700	
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	45	
Yield Strain	50mm/min	ISO 527-2/1A	%	15	
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	>100	
Flexural Modulus	2mm/min	ISO 178	MPa	1500	
Flexural Strength	2mm/min	ISO 178	MPa	60	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m^2	90	
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m^2	25	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	220	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	55	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	
Automotive interior flammability	Burn rate	FMVSS302	mm/min	<30	
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

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