

RADILON S ERV3904 333 NER

Material code Colour code

DESCRIPTION

PA6 35% glass fiber reinforced injection moulding grade. Toughened. Black colour.

Suitable for parts requiring high stiffness and mechanical reinforcement.

ISO 1043 : PA6-I GF35

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:
240 ÷ 280 °C	80 ÷ 90 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet



Underwriters Laboratories Inc. certified material. File number: E116324 www.ul.com

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	1380	
Moulding shrinkage – Parallel / Normal	280/80/30***	ISO 294-4	%	0.4 / 1.0	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	2.1	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	8	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	10900	7500
Stress at Break	5mm/min	ISO 527-2/1A	MPa	165	110
Strain at Break	5mm/min	ISO 527-2/1A	%	2.9	5
Flexural Modulus	2mm/min	ISO 178	MPa	9400	6500
Flexural Strength	2mm/min	ISO 178	MPa	250	180
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	75	85
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	75	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	14	18
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	10	
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	205	
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	215	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	210	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	
Glow Wire Flammability Index	2mm	IEC 60695-2-1/2	°C/mm	700	
Glow Wire Ignition Temperature	2mm	IEC 60695-2-1/3	°C/mm	725	
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]

