

RADILON S RV400K 333 NER

Material code Colour code

DESCRIPTION

PA6 40% glass fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring high stiffness, good mechanical resistance and good heat ageing properties retention.

ISO 1043 : PA6-T GF40

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	1440	
Moisture absorption 23°C – 50%RH	ISO 62	%	1.5	
Water absorption, immersion at 23°C	ISO 62	%	6	
Mechanical Properties				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	13000 9000
Stress at Break	5mm/min	ISO 527-2/1A	MPa	200 120
Strain at Break	5mm/min	ISO 527-2/1A	%	3.1 3.4
Flexural Modulus	2mm/min	ISO 178	MPa	11800
Flexural Strength	2mm/min	ISO 178	MPa	300
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	95 105
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	90
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	13 22
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
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
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]

