





### RADILON A RV250W 333 BK

### DESCRIPTION

PA66 25% glass fibre reinforced injection moulding grade. Heat stabilized. Black colour.

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

ISO 1043: PA66-GF25

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

### 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.

Injection Molding Processing Parameters Melt Temperature 280 - 300°C

Mold Temperature 80 - 100°C Injection Speed medium-high

### PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet ROHS compliant 2011/65/EU and following amendments

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PROPERTY		STANDARD	UNIT	<i>VALUE</i> DAM <sup>*</sup> Cond <sup>**</sup>	
PHYSICAL PROPERTIES					
Density Moulding shrinkage - Parallel / Normal Water Absorption, immersion at 23°C Moisture Absorption 23°C - 50%RH	300/90/60 <sup>[1]</sup> 2mm 2mm	ISO 1183 ISO 294-4 ISO 62 ISO 62	kg/m³ % % %	1320 0.4 / 1.0 7 1.8	
MECHANICAL PROPERTIES					
Tensile Modulus Stress at Yield Yield Strain Stress at Break Strain at Break Flexural Modulus Flexural Strength Charpy Impact Strength Charpy Impact Strength Charpy Notched Impact Strength Charpy Notched Impact Strength	1mm/min 50mm/min 50mm/min 5mm/min 5mm/min 2mm/min 2mm/min +23°C -30°C +23°C -30°C	ISO 527-2/1A ISO 527-2/1A ISO 527-2/1A ISO 527-2/1A ISO 527-2/1A ISO 178 ISO 179/1eU ISO 179/1eU ISO 179/1eA ISO 179/1eA	MPa MPa % MPa % MPa MPa kJ/m² kJ/m² kJ/m² kJ/m²	8000 - - 160 3.5 7300 240 65 55 10	5800 100 4.7 100 8 75
THERMAL PROPERTIES					
Melting Temperature Heat Deflection Temperature Heat Deflection Temperature Vicat Softening Temperature	10°C/min 1.80 MPa 0.45 MPa 50°C/h 50N	ISO 11357-1/-3 ISO 75/2Af ISO 75/2Bf ISO 306	°C °C °C	260 245 250 250	
FLAMMABILITY PROPERTIES					
Flammability Glow Wire Flammability Index Automotive Interior Flammability	0.8mm 2mm 3mm	UL 94 IEC 60695-2-12 ISO 3795	class °C mm/min	HB 700 0	
ELECTRICAL PROPERTIES					
Volume Resistivity Surface Resistivity Comparative Tracking Index	500V 500V Sol.A	IEC 62631-3-1 IEC 62631-3-2 IEC 60112	Ohm*m Ohm V	1E13 1E12 500	1E11 1E10

<sup>\*:</sup> DAM = Dry As Moulded state according to ISO 16396-2 , \*\*: Cond = Conditioned state similar to ISO 1110

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<sup>1:</sup> Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]





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#### DIAGRAMS Stress-strain (cond.) Stress-strain (dry) 150 200 — 23 °C -30 °C 23 °C Y - Yield 85 °C 125 °C 150 °C 150 − 170 °C 100 B - Break Y - Yield Stress MPa Stress MPa 100 50 0 n 3 4 5 4 8 10 Strain % Strain % Secant modulus-strain (cond.) Secant modulus-strain (dry) 10000 6000 — 23 °C -30 °C 23 °C Y - Yield 85 °C 125 °C 8000 - 150 °C 5000 — 170 °C B - Break Secant modulus MPa Secant modulus MPa Y - Yield 6000 4000 4000 3000 2000 2000 0 0 10 2

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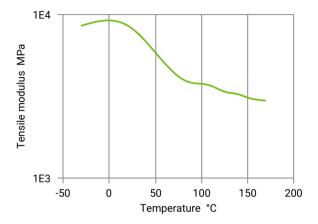
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### Tensile modulus-temperature (dry)



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