

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

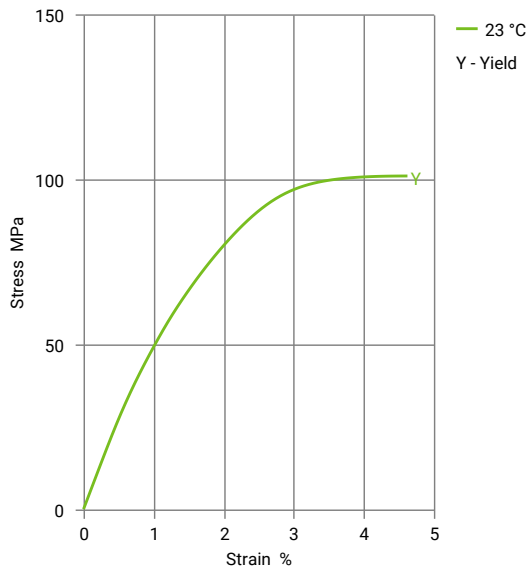
*: DAM = Dry As Moulded state according to ISO 16396-2, **: Cond = Conditioned state similar to ISO 1110

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

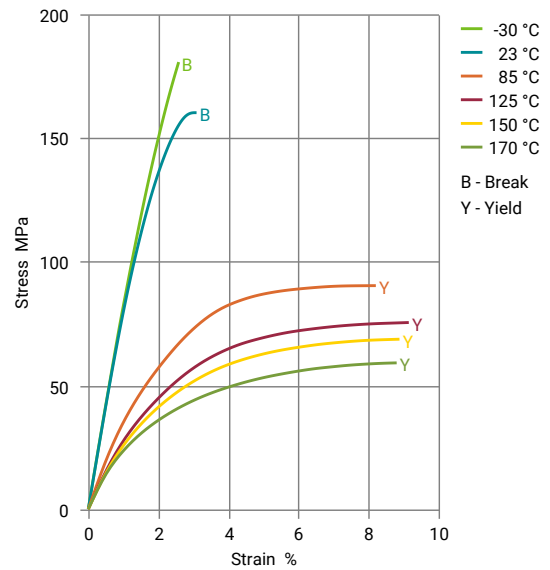
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DIAGRAMS

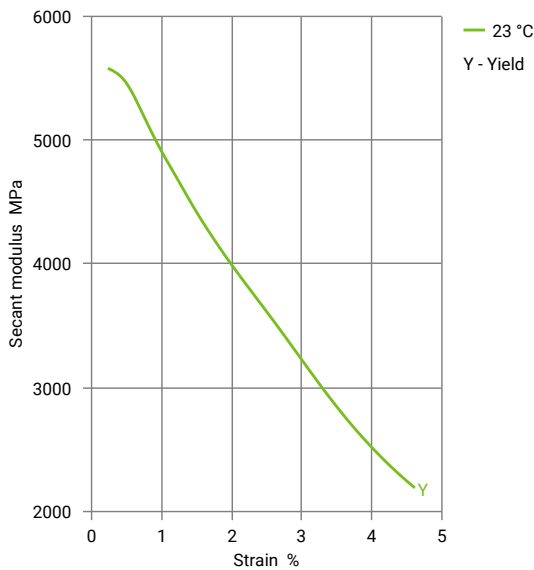
Stress-strain (cond.)



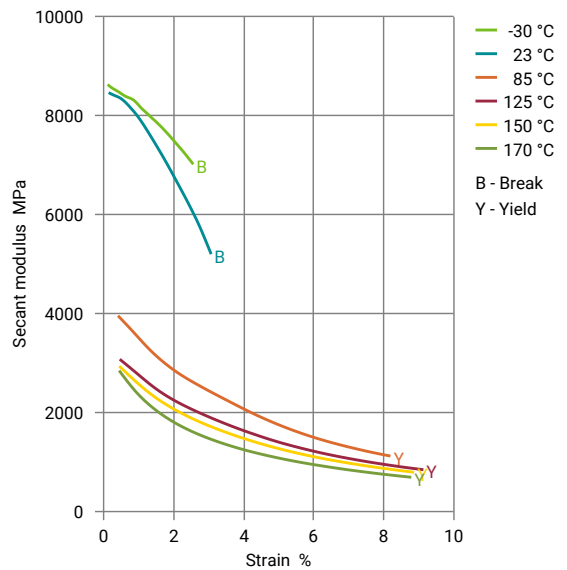
Stress-strain (dry)



Secant modulus-strain (cond.)



Secant modulus-strain (dry)



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Tensile modulus-temperature (dry)

