

Radilon® S EP25TW 3734 BK

 Radici Group High Performance Polymers - *Polyamide 6*
General Information
Product Description

Polyamide 6 compound formulated primarily for flexible extrusion applications, in particular flexible tubing and convolute tubing.

This product exhibits a balance of outstanding chemical resistance, flexibility, ductility and toughness.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Ductile	• Good Flexibility • Good Toughness	
Uses	• Automotive Applications		
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• STELLANTIS MS-DB-41 CPN2785	• STELLANTIS MS-DB-41 CPN4951	
Processing Method	• Extrusion	• Injection Molding	
Resin ID (ISO 1043)	• PA6.I		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (235°C/2.16 kg)	29	g/10 min	ISO 1133
Molding Shrinkage ²			ISO 294-4
Across Flow	1.5	%	
Flow	1.3	%	
Viscosity Index - Sulfuric Acid	3880	in ³ /lb	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	131000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	6530	psi	ISO 527-2/1A/50
Flexural Modulus ³	138000	psi	ISO 178
Flexural Stress ³	4640	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	4.3	ft·lb/in ²	
73°F	12	ft·lb/in ²	
Charpy Unnotched Impact Strength (73°F)	No Break		ISO 179/1eU
Notched Izod Impact Strength			ISO 180/1A
-22°F	4.8	ft·lb/in ²	
73°F	11	ft·lb/in ²	
Unnotched Izod Impact Strength (73°F)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	246	°F	ISO 75-2/Bf
Deflection Temperature Under Load (264 psi, Unannealed)	113	°F	ISO 75-2/Af
Melting Temperature ⁴	428	°F	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Desiccant Dryer	176	°F



Drying Time - Desiccant Dryer	2.0 to 4.0 hr
Dew Point - Desiccant Dryer	< -4 °F
Suggested Max Moisture	0.10 %
Processing (Melt) Temp	428 to 500 °F
Mold Temperature	104 to 158 °F
Injection Rate	Moderate
Extrusion	Nominal Value Unit
Melt Temperature	428 to 482 °F

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² 280°C Melt Temperature/ 70°C Mold Temperature/ 50 MPa Cavity Pressure
- ³ 0.079 in/min
- ⁴ 10°C/min

