

**Radiflam® A RV250K AE 321 C BK**

 Radici Group High Performance Polymers - *Polyamide 66*

## General Information

**Product Description**

PA66 flame retardant injection moulding grade. 25% glass fiber reinforced. Black colour.

Suitable for parts requiring fire retardancy, medium stiffness and good mechanical resistance. Rated V-0 according to UL-94.

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant • Medium Stiffness
Agency Ratings	• EU 2011/65/EC
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA66-T GF25 FR(17+72)

 Properties <sup>1</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.57	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>2</sup>				ISO 294-4
Across Flow	0.90	--	%	
Flow	0.40	--	%	
Water Absorption (Saturation, 73°F, 0.0787 in)	3.8	--	%	ISO 62
Water Absorption (Equilibrium, 73°F, 0.0787 in, 50% RH)	1.0	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.48E+6	1.38E+6	psi	ISO 527-1/1A/1
Tensile Stress (Break)	20300	13800	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	2.5	%	ISO 527-2/1A/5
Flexural Modulus <sup>3</sup>	1.38E+6	--	psi	ISO 178
Flexural Stress <sup>3</sup>	30000	--	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.8	5.2	ft·lb/in <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	19	21	ft·lb/in <sup>2</sup>	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	437	--	°F	ISO 75-2/1Af
Vicat Softening Temperature	464	--	°F	ISO 306/B50
Ball Pressure Test (> 365°F)	Pass	--		IEC 60695-10-2
Melting Temperature <sup>4</sup>	500	--	°F	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity (500 V)	1.0E+12	1.0E+10	ohms	IEC 62631-3-2
Volume Resistivity (500 V)	1.0E+13	1.0E+11	ohms·m	IEC 62631-3-1
Comparative Tracking Index (Solution A)	350	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.031 in)	V-0	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.04 in	1760	--	°F	



0.08 in	1760	--	°F
Glow Wire Ignition Temperature			IEC 60695-2-13
0.04 in	1560	--	°F
0.08 in	1560	--	°F

### Processing Information

Injection	Dry 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	536 to 572 °F
Mold Temperature	176 to 212 °F
Injection Rate	Moderate-Fast

### Notes

- <sup>1</sup> Typical properties: these are not to be construed as specifications.
- <sup>2</sup> 280°C Melt Temperature, 80°C Mold Temperature, 60 MPa Cavity Pressure
- <sup>3</sup> 0.079 in/min
- <sup>4</sup> 10°C/min

