

Radilon® DT HSW 3733 BK

 Radici Group High Performance Polymers - *Polyamide 612*
General Information
Product Description

PA612 injection moulding grade. Nucleated and lubricated, fast cycling. Heat stabilized. Black colour.

General purpose grade, suitable for parts requiring high productivity.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer	• Lubricant	• Nucleating Agent
Features	• Fast Molding Cycle • General Purpose	• Heat Stabilized • Lubricated	• Nucleated
Uses	• General Purpose		
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA612		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Molding Shrinkage ²			ISO 294-4
Across Flow	1.1	%	
Flow	1.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	344000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	9720	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	26	%	ISO 527-2/1A/50
Flexural Modulus ³	334000	psi	ISO 178
Flexural Stress ³	11700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	2.2	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ⁴	415	°F	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.031 in)	V-2		UL 94

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	446 to 500	°F
Mold Temperature	158 to 176	°F
Injection Rate	Moderate	



¹ Typical properties: these are not to be construed as specifications.

² 270°C Melt Temperature, 60°C Mold Temperature, 60 MPa Cavity Pressure

³ 0.079 in/min

⁴ 10°C/min

