

RADIFLAM A RV250 HFL 3932 BK

DESCRIPTION

PA66 flame retardant injection moulding grade, halogen and red phosphorus free. 25% glass fibre reinforced. Black colour.

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Good electrical insulating properties. Rated V-0 according to UL-94.

ISO 1043: PA66-GF25 FR(40)

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 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. 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
Underwriters Laboratories Inc. certified material www.ul.com
ROHS compliant 2011/65/EU and following amendments



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PROPERTY	STANDARD	UNIT	VALUE DAM*	Cond**
PHYSICAL PROPERTIES				
Density		kg/m ³	1380	
Moulding shrinkage - Parallel / Normal	280/80/60 ^[1]	%	0.3 / 0.9	
Water Absorption, immersion at 23°C	2mm	%	4.8	
Moisture Absorption 23°C - 50%RH	2mm	%	1.4	
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	MPa	9300	
Stress at Break	5mm/min	MPa	130	
Strain at Break	5mm/min	%	3	
Flexural Modulus	2mm/min	MPa	9500	
Flexural Strength	2mm/min	MPa	220	
Charpy Impact Strength	+23°C	kJ/m ²	69	
Charpy Notched Impact Strength	+23°C	kJ/m ²	10	
THERMAL PROPERTIES				
Melting Temperature	10°C/min	°C	260	
FLAMMABILITY PROPERTIES				
Flammability	0.8mm	class	V-0	
Glow Wire Flammability Index	1mm	°C	960	
Glow Wire Flammability Index	2mm	°C	960	
Automotive Interior Flammability	3mm	mm/min	0	
ELECTRICAL PROPERTIES				
Volume Resistivity	500V	Ohm*m	1E13	1E11
Surface Resistivity	500V	Ohm	1E12	1E10
Comparative Tracking Index	Sol.A	V	600	

*: 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]

