



RADIFLAM A RV250 FR 100 NT

PROVISIONAL

DESCRIPTION

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

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Low smoke toxicity and optical density. Rated V-0 according to UL-94.

ISO 1043: PA66-GF25 FR(61+72)

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS

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. 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	ISO 1183	kg/m ³	1740	
Moulding shrinkage - Parallel / Normal	ISO 294-4	%	0.4 / 0.8	
Water Absorption, immersion at 23°C	ISO 62	%	2.5	
Moisture Absorption 23°C - 50%RH	ISO 62	%	1.1	
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	14600	8800
Stress at Break	ISO 527-2/1A	MPa	155	95
Strain at Break	ISO 527-2/1A	%	2.1	2.3
Flexural Modulus	ISO 178	MPa	14000	7900
Flexural Strength	ISO 178	MPa	240	130
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	50	60
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	5	8
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	260	
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class	V-0	
Glow Wire Flammability Index	IEC 60695-2-12	°C	960	
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Limiting Oxygen Index	ISO 4589-2	%	45	
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	1E11
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	1E10

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

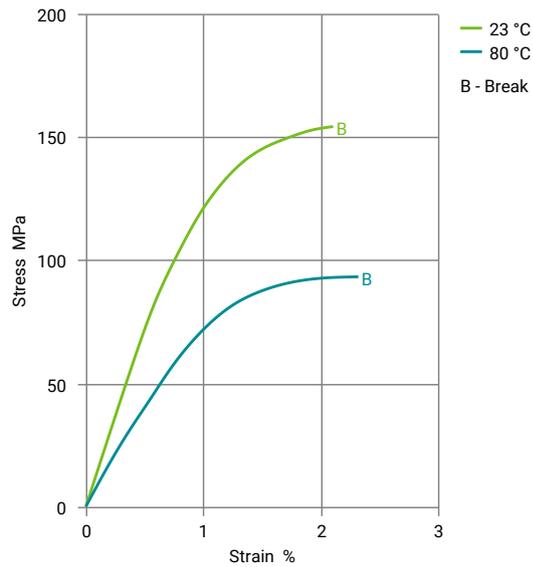
1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



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DIAGRAMS

Stress-strain (dry)



Secant modulus-strain (dry)

