

RADILON A ERV250K 3133 BK

PROVISIONAL

DESCRIPTION

PA66 25% glass fibre reinforced extrusion grade. Toughened and Heat stabilized. Black colour.

Material especially developed for extrusion of thermal-breaker profiles for doors and windows. Also suitable for injection moulding.

ISO 1043: PA66-GF25

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. 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

Extrusion Temperature
270 - 290°C

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet
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	1310	
Melt Flow Rate	ISO 1133	g/10min		17
Moulding shrinkage - Parallel / Normal	ISO 294-4	%	0.5 / 0.7	
Water Absorption, immersion at 23°C	ISO 62	%	7.4	
Moisture Absorption 23°C - 50%RH	ISO 62	%	1.7	
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	7900	5300
Stress at Break	ISO 527-2/1A	MPa	150	90
Strain at Break	ISO 527-2/1A	%	3	5.5
Flexural Modulus	ISO 178	MPa	7100	
Flexural Strength	ISO 178	MPa	215	
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	74	80
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C		260
Heat Deflection Temperature	ISO 75/2Af	°C		240
Thermal Conductivity	-	W/(m K)		0.3
Coeff. of Linear Therm. Expansion	ISO 11359-1/-2	E-6/K		30
Coeff. of Linear Therm. Expansion	ISO 11359-1/-2	E-6/K		65
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class		HB
Glow Wire Flammability Index	IEC 60695-2-12	°C		700
Automotive Interior Flammability	ISO 3795	mm/min		<10
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: Temperature [°C] / Load [kg]

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

