

RADILON A ERV250K 333 BK

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

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 - 280°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					
Melt Flow Rate	275/5 ^[1]	ISO 1183	kg/m³	1310	
Moulding shrinkage - Parallel / Normal	290/80/60 ^[2]	ISO 1133	g/10min	17	
Water Absorption, immersion at 23°C	2mm	ISO 294-4	%	0.5 / 0.7	
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	7.4	
		ISO 62	%	1.8	
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	8000	4600
Stress at Break	5mm/min	ISO 527-2/1A	MPa	145	90
Strain at Break	5mm/min	ISO 527-2/1A	%	3.2	5
Flexural Modulus	2mm/min	ISO 178	MPa	6900	3600
Flexural Strength	2mm/min	ISO 178	MPa	220	125
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m²	75	90
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m²	16	15
THERMAL PROPERTIES					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	260	
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	205	
Vicat Softening Temperature	50°C/h 50N	ISO 306	°C	210	
Thermal Conductivity	23°C, inplane	-	W/(m K)	0.3	
Coeff. of Linear Therm. Expansion	parallel, 23°C-55°C	ISO 11359-1/-2	E-6/K	30	
Coeff. of Linear Therm. Expansion	normal, 23°C-55°C	ISO 11359-1/-2	E-6/K	65	
FLAMMABILITY PROPERTIES					
Flammability	0.8mm	UL 94	class	HB	
Glow Wire Flammability Index	2mm	IEC 60695-2-12	°C	700	
Automotive Interior Flammability	3mm	ISO 3795	mm/min	<10	
ELECTRICAL PROPERTIES					
Volume Resistivity	500V	IEC 62631-3-1	Ohm*m	1E13	1E11
Surface Resistivity	500V	IEC 62631-3-2	Ohm	1E12	1E10
Comparative Tracking Index	Sol.A	IEC 60112	V	550	

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

1: Temperature [°C] / Load [kg]

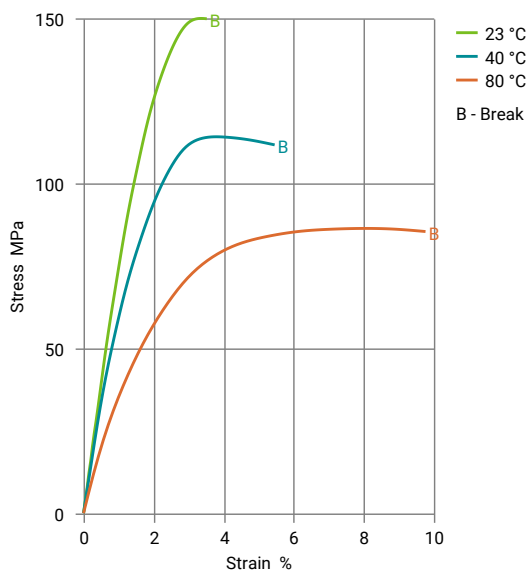
2: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



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DIAGRAMS

Stress-strain (dry)



Secant modulus-strain (dry)

