

RADILON A HSK 164 NT

DESCRIPTION

PA66 injection moulding grade. Internally lubricated, fast cycles, easy mould release. Heat stabilized. Natural colour.

Suitable for high productivity applications like fasteners, connectors, cable ties.

ISO 1043: PA66

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
270 - 290°C

Mold Temperature
70 - 90°C

Injection Speed
medium

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			1140	
Moulding shrinkage - Parallel / Normal	290/70/60 ^[1]	ISO 1183 ISO 294-4	kg/m ³ %	1.2 / 1.3
Water Absorption, immersion at 23°C	2mm	ISO 62	%	8.9
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	2.1
Viscosity Index (Sulfuric Acid)		ISO 307	ml/g	140
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2900
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	80
Yield Strain	50mm/min	ISO 527-2/1A	%	4.5
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	30
Flexural Modulus	2mm/min	ISO 178	MPa	2900
Flexural Strength	2mm/min	ISO 178	MPa	115
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	N
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	5.3
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m ²	4.5
THERMAL PROPERTIES				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	260
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	70
Heat Deflection Temperature	0.45 MPa	ISO 75/2Bf	°C	200
Vicat Softening Temperature	50°C/h 50N	ISO 306	°C	240
Coeff. of Linear Therm. Expansion	parallel, 23°C-55°C	ISO 11359-1/-2	E-6/K	85
Coeff. of Linear Therm. Expansion	normal, 23°C-55°C	ISO 11359-1/-2	E-6/K	85
FLAMMABILITY PROPERTIES				
Flammability	0.4mm	UL 94	class	V-2
Flammability	0.8mm	UL 94	class	V-2
Glow Wire Flammability Index	2mm	IEC 60695-2-12	°C	800
Automotive Interior Flammability	3mm	ISO 3795	mm/min	0
ELECTRICAL PROPERTIES				
Volume Resistivity	500V	IEC 62631-3-1	Ohm*m	1E13
Surface Resistivity	500V	IEC 62631-3-2	Ohm	1E12
Comparative Tracking Index	SoI.A	IEC 60112	V	600

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

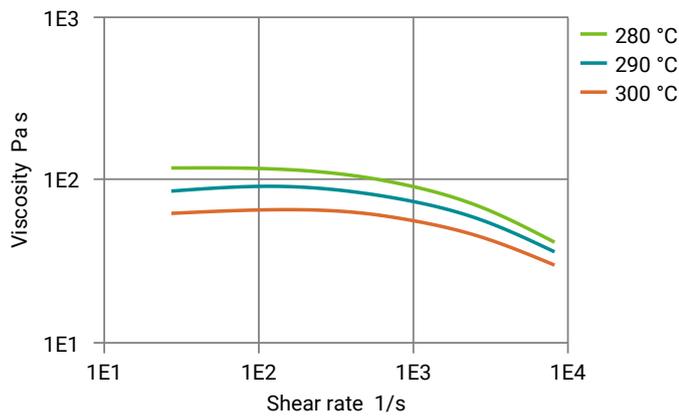
1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



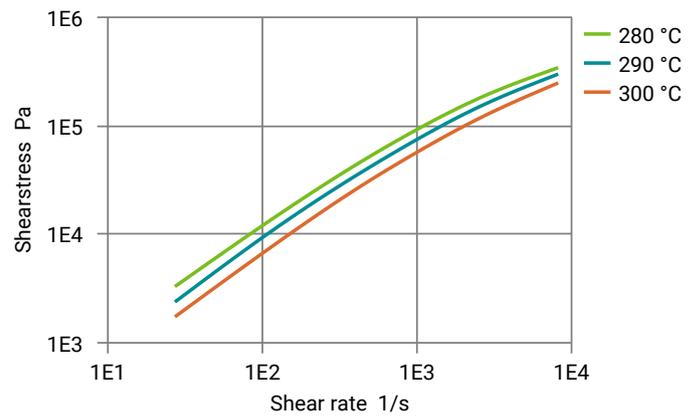
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DIAGRAMS

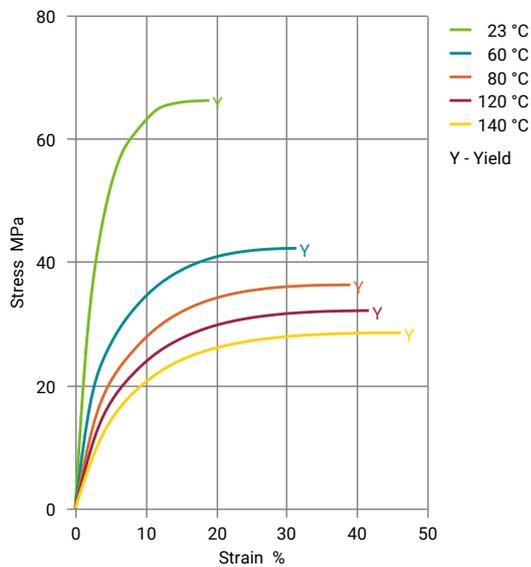
Viscosity-shear rate



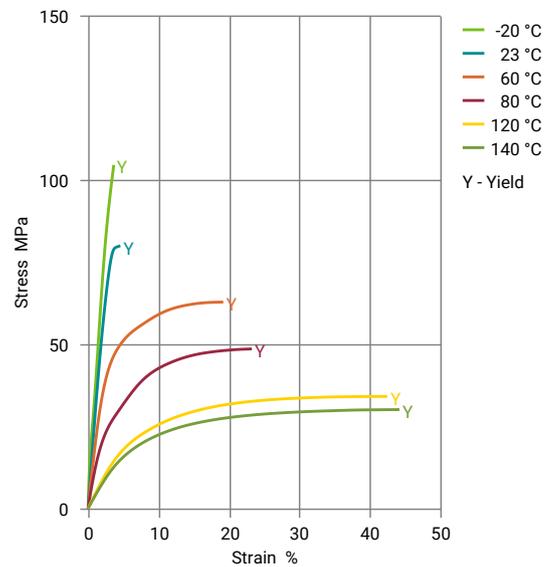
Shearstress-shear rate



Stress-strain (cond.)

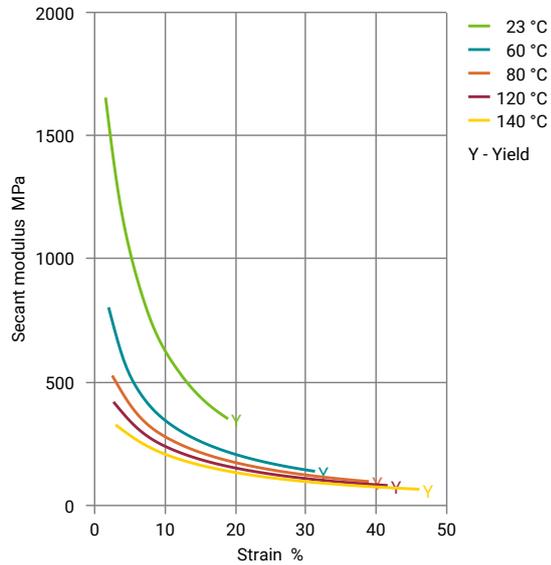


Stress-strain (dry)



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Secant modulus-strain (cond.)



Secant modulus-strain (dry)

