

RADILON A RV350X2N 333 BK

DESCRIPTION

PA66 35% glass fibre reinforced injection moulding grade with superior thermal resistance in contact with hot air. High improvement of mechanical properties retention versus standard polyamide 66 after heat ageing. Electrically neutral heat stabilization. Black colour.

Suitable for parts requiring high stiffness, good mechanical resistance and excellent heat ageing properties retention.

ISO 1043: PA66-GF35

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

Formerly Known As Torzen Marathon G3500X2HL BK34

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

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	1410	
Water Absorption, immersion at 23°C	ISO 62	%		5.5
Water Absorption, 24h immersion at 23°C	ISO 62	%		1.1
Water Absorption, 24h immersion at 23°C	ISO 62	%		2
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.7
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	10800	7000
Stress at Break	ISO 527-2/1A	MPa	185	120
Strain at Break	ISO 527-2/1A	%	3.5	7.5
Flexural Modulus	ISO 178	MPa	10200	6800
Flexural Strength	ISO 178	MPa	290	195
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	95	
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	60	
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	14	15
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	10	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C		260
Heat Deflection Temperature	ISO 75/2Af	°C		250
Heat Deflection Temperature	ISO 75/2Bf	°C		260
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class		HB
Glow Wire Flammability Index	IEC 60695-2-12	°C		700
Automotive Interior Flammability	ISO 3795	mm/min		0
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	

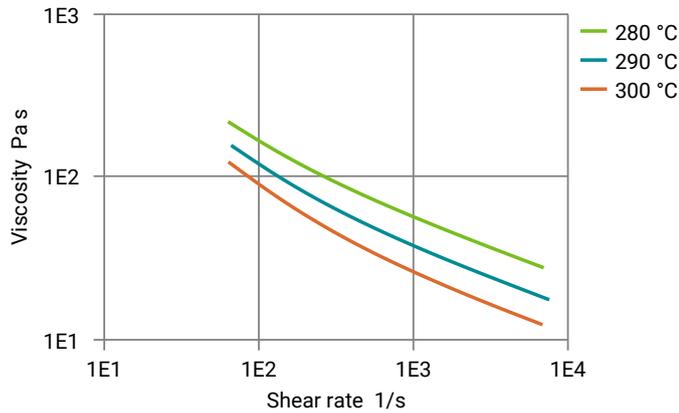
*: DAM = Dry As Moulded state according to ISO 16396-2, **: Cond = Conditioned state similar to ISO 1110



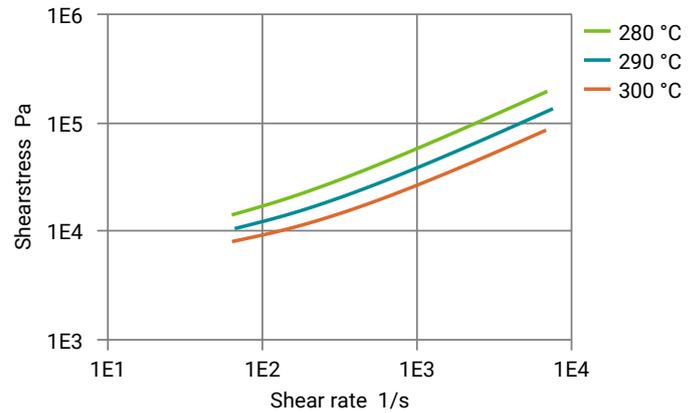
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DIAGRAMS

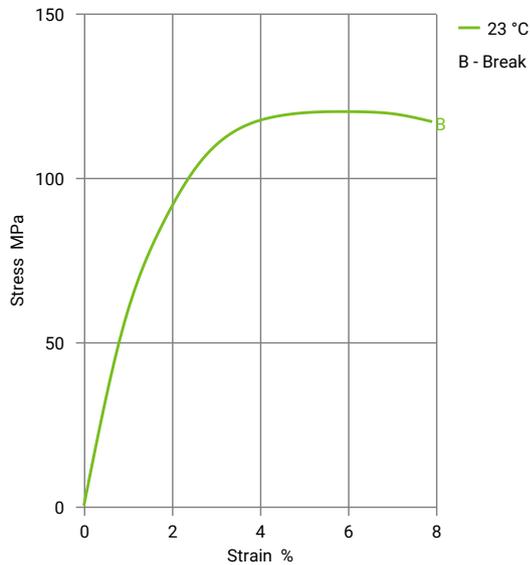
Viscosity-shear rate



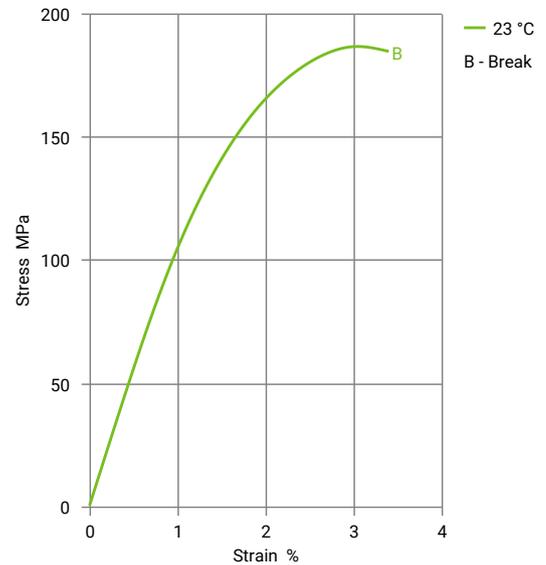
Shearstress-shear rate



Stress-strain (cond.)

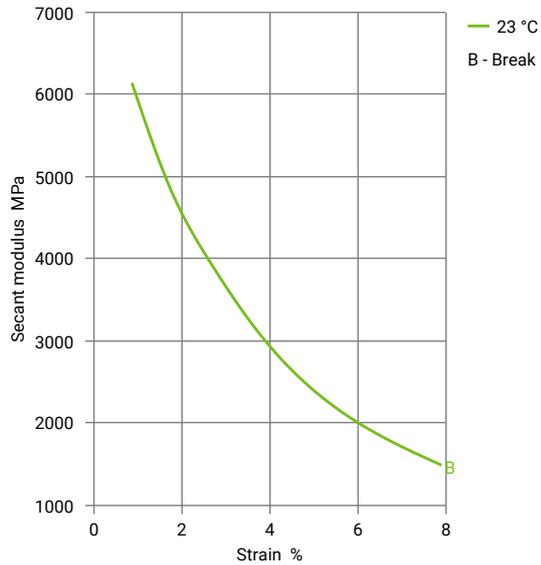


Stress-strain (dry)

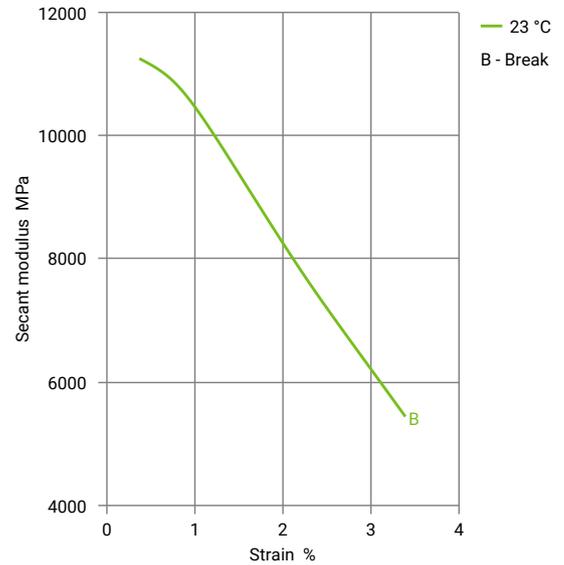


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Secant modulus-strain (cond.)



Secant modulus-strain (dry)



Specific volume-temperature (pvT)

