

# RADIFLAM S RV250 FR 100 NT

PRELIMINARY

## DESCRIPTION

PA6 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: PA6-GF25 FR(61+72)

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

*THE CHARACTERISTICS SHOWN HERE MUST BE CONSIDERED PRELIMINARY AND INDICATIVE FOR A PRODUCT AT DEVELOPMENTAL STAGE*

## 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  
240 - 280°C

Mold Temperature  
80 - 90°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](http://www.ul.com)  
ROHS compliant 2011/65/EU and following amendments



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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>PHYSICAL PROPERTIES</b>				
Density	ISO 1183	kg/m <sup>3</sup>	1760	
Water Absorption, immersion at 23°C	ISO 62	%		2.5
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.1
<b>MECHANICAL PROPERTIES</b>				
Tensile Modulus	ISO 527-2/1A	MPa	15300	
Stress at Break	ISO 527-2/1A	MPa	150	
Strain at Break	ISO 527-2/1A	%	2	
Flexural Modulus	ISO 178	MPa	15400	
Flexural Strength	ISO 178	MPa	245	
Charpy Impact Strength	ISO 179/1eU	kJ/m <sup>2</sup>	50	
<b>THERMAL PROPERTIES</b>				
Melting Temperature	ISO 11357-1/-3	°C		220
Heat Deflection Temperature	ISO 75/2Af	°C		200
Heat Deflection Temperature	ISO 75/2Bf	°C		215
Vicat Softening Temperature	ISO 306	°C		205
<b>FLAMMABILITY PROPERTIES</b>				
Flammability	UL 94	class		V-0
Glow Wire Flammability Index	IEC 60695-2-12	°C		960
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Glow Wire Ignition Temperature	IEC 60695-2-13	°C		725
Glow Wire Ignition Temperature	IEC 60695-2-13	°C		725
Automotive Interior Flammability	ISO 3795	mm/min		0
Limiting Oxygen Index	ISO 4589-2	%		45
<b>ELECTRICAL PROPERTIES</b>				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	1E11
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	1E10
Comparative Tracking Index	IEC 60112	V	600	

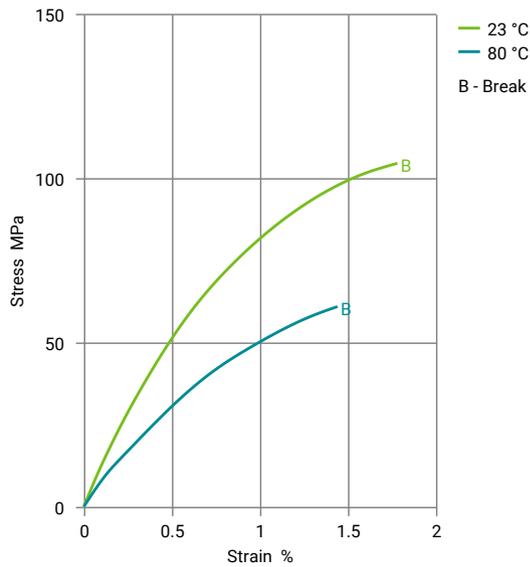
\*: DAM = Dry As Moulded state according to ISO 16396-2, \*\*: Cond = Conditioned state similar to ISO 1110



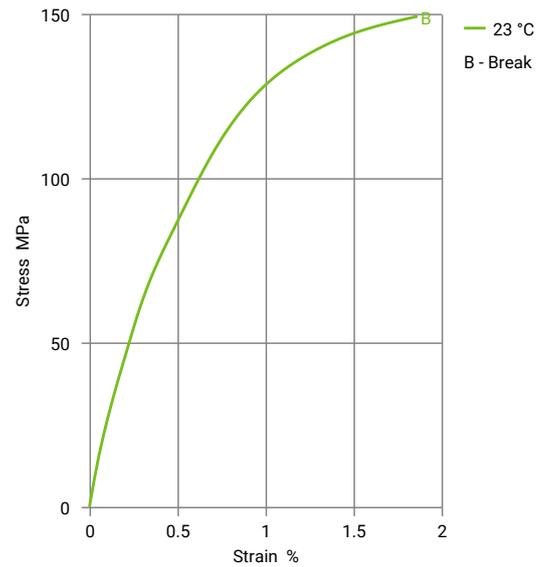
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## DIAGRAMS

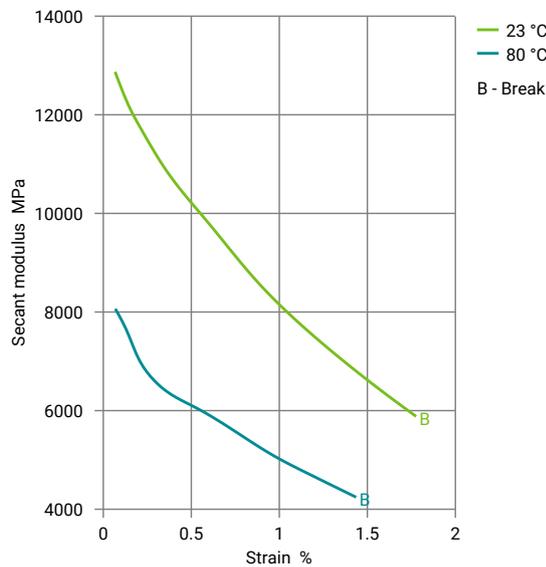
### Stress-strain (cond.)



### Stress-strain (dry)



### Secant modulus-strain (cond.)



### Secant modulus-strain (dry)

