

RADIFLAM S RV250 FR 339 E NER

Material code Colour code

DESCRIPTION

PA6 flame retardant injection moulding grade, halogen and phosphorus free. 25% glass fiber reinforced. Deep black colour.

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Low smoke toxicity and optical density. Applications in underground railway sector. Rated V-0 according to UL-94.

ISO 1043 : PA6 GF25 FR(61)

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. 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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
260 ÷ 290 °C	80 ÷ 90 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet



Underwriters Laboratories Inc. certified material. File number: E116324 www.ul.com

RoHS compliant 2002/95/CE and following amendments





Technical data sheet

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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
Physical Properties				
Density	ISO 1183	Kg/m ³	1680	
Moisture absorption 23°C – 50%RH	2mm thk ISO 62	%	1.1	
Water absorption, immersion at 23°C	2mm thk ISO 62	%	2.5	
Mechanical Properties				
Tensile Modulus	1mm/min ISO 527-2/1A	MPa	14500	11000
Stress at Break	5mm/min ISO 527-2/1A	MPa	140	105
Strain at Break	5mm/min ISO 527-2/1A	%	1.8	1.9
Flexural Modulus	2mm/min ISO 178	MPa	14000	
Flexural Strength	2mm/min ISO 178	MPa	220	
Charpy Impact Strength	+23°C ISO 179/1 eU	KJ/m ²	35	40
Charpy Impact Strength	-30°C ISO 179/1 eU	KJ/m ²	25	
Charpy Notched Impact Strength	+23°C ISO 179/1 eA	KJ/m ²	4.5	6.5
Charpy Notched Impact Strength	-30°C ISO 179/1 eA	KJ/m ²	4	
Thermal Properties				
Melting Temperature	10°C/min ISO 11357-1-3	°C	220	
Heat Deflection Temperature	1.8 MPa ISO 75/2 A f	°C	200	
Heat Deflection Temperature	0.45 MPa ISO 75/2 B f	°C	215	
Vicat Softening Temperature	50°C/h ISO 306/B50 50N	°C	205	
Flammability Properties				
Flammability	1.6mm UL 94	class	V0	
Glow Wire Flammability Index	1mm / 2mm IEC 60695-2-1/2	°C/mm	960 / 960	
Glow Wire Ignition Temperature	1mm / 2mm IEC 60695-2-1/3	°C/mm	725 / 725	
Automotive interior flammability	Burn rate FMVSS302	mm/min	0	
Electrical Properties				
Volume resistivity	500V IEC 60093	ohm · m	1 E+13	1 E+11
Surface resistivity	500V IEC 60093	ohm	1 E+12	1 E+10
Comparative Tracking Index	Sol.A IEC 60112	V	550	

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]

