

RADILON S BMV150K 333 BK

DESCRIPTION

PA6 15% glass fibre reinforced, high viscosity blow moulding grade. Toughened, heat stabilized. Black colour.

Suitable for blow-moulding of tubes and containers; typically used for automotive air pipes, including turbo air ducts.

ISO 1043: PA6-I-GF15

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
250 - 280°C

Mold Temperature
70 - 80°C

Injection Speed
medium

Extrusion Temperature
250 - 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		kg/m ³	1200	
Melt Flow Rate	275/5 ^[1]	g/10min		4.2
Moulding shrinkage - Parallel / Normal	280/90/60 ^[2]	%		1.0 / 0.7
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	5000
Stress at Break	5mm/min	ISO 527-2/1A	MPa	95
Strain at Break	5mm/min	ISO 527-2/1A	%	4.8
Flexural Modulus	2mm/min	ISO 178	MPa	4200
Flexural Strength	2mm/min	ISO 178	MPa	150
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	75
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	20
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m ²	7
THERMAL PROPERTIES				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	140
Coeff. of Linear Therm. Expansion	parallel, 23°C-55°C	ISO 11359-1/-2	E-6/K	39
Coeff. of Linear Therm. Expansion	normal, 23°C-55°C	ISO 11359-1/-2	E-6/K	143
FLAMMABILITY PROPERTIES				
Flammability	0.8mm	UL 94	class	HB
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

*: 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

Thermal expansion

