

RADILON S BMX200K 333 BK

DESCRIPTION

PA6 high viscosity blow moulding grade. Toughened, heat stabilized. Black colour.

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

ISO 1043: PA6-HI

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	ISO 1183	kg/m ³	1060	
Melt Flow Rate	ISO 1133	g/10min		2
Moulding shrinkage - Parallel / Normal	ISO 294-4	%	1.4 / 1.1	
Water Absorption, immersion at 23°C	ISO 62	%	5.5	
Moisture Absorption 23°C - 50%RH	ISO 62	%	1.6	
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	1700	850
Stress at Yield	ISO 527-2/1A	MPa	42	35
Yield Strain	ISO 527-2/1A	%	4.5	
Nominal Strain at Break	ISO 527-2/1A	%	>100	>100
Flexural Modulus	ISO 178	MPa	1600	750
Flexural Strength	ISO 178	MPa	60	40
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	105	120
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	25	
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	220	
Heat Deflection Temperature	ISO 75/2Af	°C	55	
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class		HB
Automotive Interior Flammability	ISO 3795	mm/min		<30
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m	1E13	1E11
Surface Resistivity	IEC 62631-3-2	Ohm	1E12	1E10

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

1: Temperature [°C] / Load [kg]

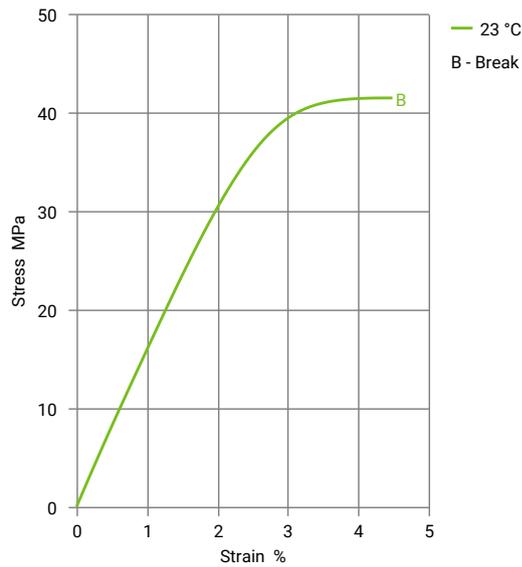
2: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



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DIAGRAMS

Stress-strain (dry)



Secant modulus-strain (dry)

