

RADILON S ERV100 FR2 333 BK

DESCRIPTION

PA6 10% glass fibre reinforced flame retardant injection moulding grade. Halogen and phosphorus free. Toughened. Black colour.

Suitable for parts requiring improved impact strength along with enhanced stiffness. Rated V-2 according to UL-94.

ISO 1043: PA6-GF10 FR(30)

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

Formerly Known As X19056

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
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
ROHS compliant 2011/65/EU and following amendments



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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density			1220	
Moulding shrinkage - Parallel / Normal	270/80/60 ^[1]	ISO 1183 ISO 294-4	kg/m ³ %	0.8 / 1.0
Water Absorption, immersion at 23°C	2mm	ISO 62	%	6.5
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	1.9
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	4900
Stress at Break	5mm/min	ISO 527-2/1A	MPa	100
Strain at Break	5mm/min	ISO 527-2/1A	%	3.9
Flexural Modulus	2mm/min	ISO 178	MPa	4700
Flexural Strength	2mm/min	ISO 178	MPa	160
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	50
Charpy Impact Strength	-30°C	ISO 179/1eU	kJ/m ²	38
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	5
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m ²	4.8
THERMAL PROPERTIES				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	218
FLAMMABILITY PROPERTIES				
Flammability	0.8mm	UL 94	class	V-2
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: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]

