

RADILON S RV250 FR2 5138 OR

PRELIMINARY

DESCRIPTION

PA6 25% glass fibre reinforced flame retardant injection moulding grade. Halogen and red phosphorus free. Orange colour (comparable to RAL 2003) stable at high temperature.

Suitable for parts requiring fire retardancy along with good stiffness. Rated V-2 according to UL-94.

ISO 1043: PA6-GF25 FR(30)

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. 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
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	1380	
Water Absorption, immersion at 23°C	ISO 62	%		5.5
Moisture Absorption 23°C - 50%RH	ISO 62	%		1.3
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	6100	
Stress at Break	ISO 527-2/1A	MPa	80	
Strain at Break	ISO 527-2/1A	%		3.1
Flexural Modulus	ISO 178	MPa	6000	
Flexural Strength	ISO 178	MPa	140	
Charpy Impact Strength	ISO 179/1eU	kJ/m ²		48
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²		3.5
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C		220
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class		V-2
Glow Wire Flammability Index	IEC 60695-2-12	°C		960
Automotive Interior Flammability	ISO 3795	mm/min		0
ELECTRICAL PROPERTIES				
Volume Resistivity	IEC 62631-3-1	Ohm*m		1E13
Surface Resistivity	IEC 62631-3-2	Ohm		1E12
Comparative Tracking Index	IEC 60112	V		550

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

