

RADILON S RV350K 100 NT

DESCRIPTION

PA6 35% glass fibre reinforced injection moulding grade. Heat stabilized. Natural colour.

Suitable for parts requiring high stiffness, good mechanical resistance and good heat ageing properties retention.

ISO 1043: PA6-GF35

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
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			1400	
Moulding shrinkage - Parallel / Normal	280/90/60 ^[1]	ISO 1183	kg/m ³	
Water Absorption, immersion at 23°C	2mm	ISO 294-4	%	0.3 / 0.8
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	6.4
		ISO 62	%	1.8
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	10800
Stress at Break	5mm/min	ISO 527-2/1A	MPa	195
Strain at Break	5mm/min	ISO 527-2/1A	%	4
Flexural Modulus	2mm/min	ISO 178	MPa	10200
Flexural Strength	2mm/min	ISO 178	MPa	295
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m ²	105
Charpy Impact Strength	-30°C	ISO 179/1eU	kJ/m ²	85
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m ²	17
Charpy Notched Impact Strength	-30°C	ISO 179/1eA	kJ/m ²	12
THERMAL PROPERTIES				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	205
Heat Deflection Temperature	0.45 MPa	ISO 75/2Bf	°C	215
Vicat Softening Temperature	50°C/h 50N	ISO 306	°C	210
FLAMMABILITY PROPERTIES				
Flammability	0.8mm	UL 94	class	HB
Glow Wire Flammability Index	2mm	IEC 60695-2-12	°C	700
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

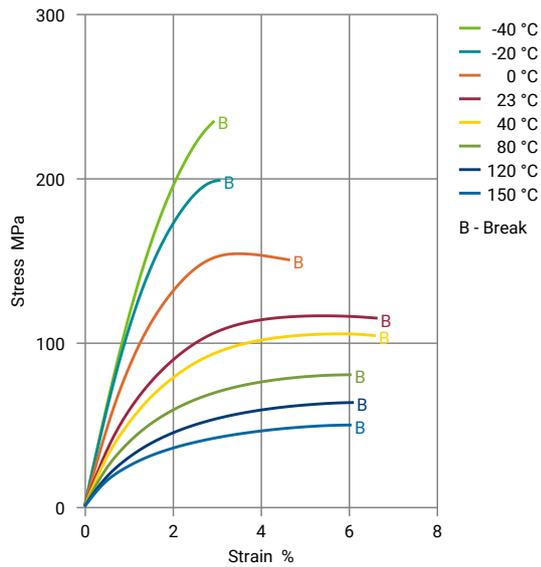
1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]



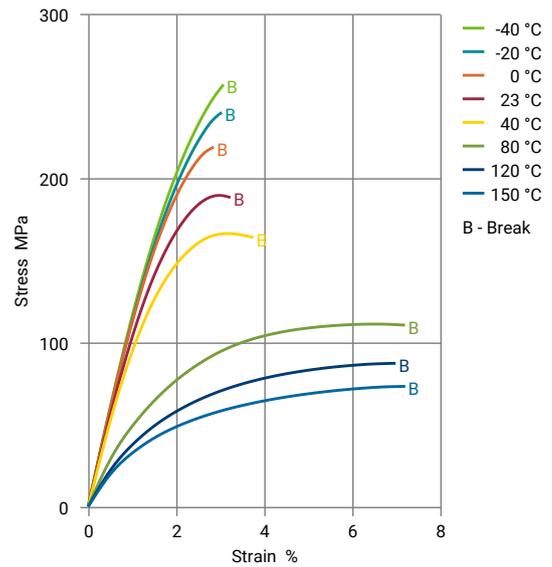
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DIAGRAMS

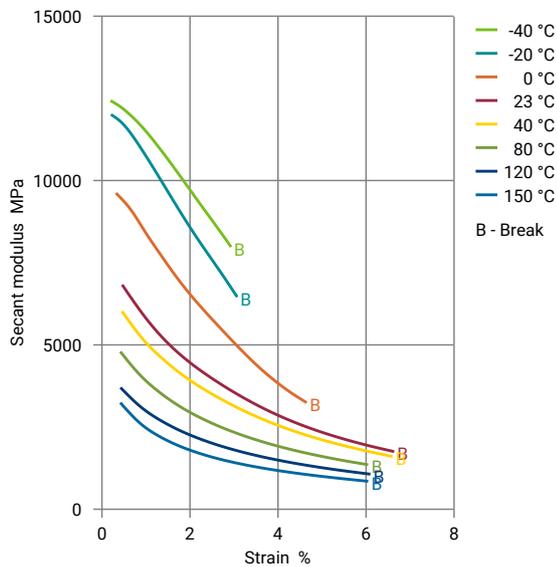
Stress-strain (cond.)



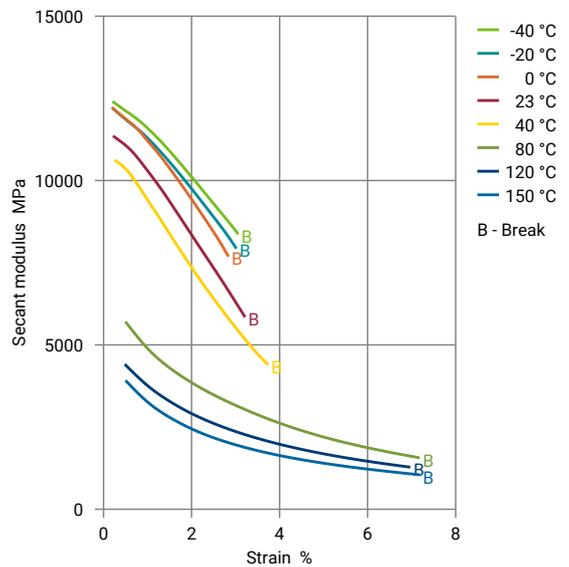
Stress-strain (dry)



Secant modulus-strain (cond.)



Secant modulus-strain (dry)



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Thermal expansion

