Radilon® S BMX200K 333 BK

Radici Group High Performance Polymers - Polyamide 6

General Information

Product 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.

General			
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Good Toughness • Heat Stabilized	• High Viscosity • Impact Modified	
Uses	• Automotive Applications • Blow Molding Applications	• Containers • Tubing	
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Processing Method	• Blow Molding	• Extrusion	• Injection Molding
Resin ID (ISO 1043)	• PA6-HI		

Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.06	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/5.0 kg	2.0	--	g/10 min	
Molding Shrinkage				ISO 294-4
Across Flow	1.1	--	%	
Flow	1.4	--	%	
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	5.5	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	1.6	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	247000	123000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	6090	5080	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	--	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 100	> 100	%	ISO 527-2/1A/50
Flexural Modulus [2]	232000	109000	psi	ISO 178
Flexural Stress [2]	8700	5800	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	12	--	ft·lb/in²	
73°F	50	57	ft·lb/in²	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				ISO 75-2/Af
264 psi, Unannealed	131	--	°F	

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Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature [3]	428	--	°F	ISO 11357-3
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity (500 V)	1.0E+12	1.0E+10	ohms	IEC 62631-3-2
Volume Resistivity (500 V)	1.0E+13	1.0E+11	ohms·m	IEC 62631-3-1
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate (0.118 in)	< 1.2	--	in/min	ISO 3795
Flame Rating (0.031 in)	HB	--		UL 94

Processing Information

Injection	Dry	Unit
Drying Temperature - Desiccant Dryer	176	°F
Drying Time - Desiccant Dryer	2.0 to 4.0	hr
Dew Point - Desiccant Dryer	< -4	°F
Suggested Max Moisture	0.15	%
Processing (Melt) Temp	482 to 536	°F
Mold Temperature	158 to 176	°F
Injection Rate	Moderate	
Extrusion	**Dry**	**Unit**
Drying Temperature	176	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Melt Temperature	482 to 536	°F

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 0.079 in/min

[3] 10°C/min