

Radiflam® A RV250 HF 333 BK

Radici Group High Performance Polymers - Polyamide 66

General Information

Product Description

PA66 flame retardant for injection molding, halogen and red phosphorus free. 25% glass fiber reinforced. Black colour.

Suitable for parts requiring flame retardancy along with medium stiffness and good mechanical resistance. Good electrical insulating properties. Rated V-0 according to UL-94.

General

Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight		
Additive	• Flame Retardant		
Features	• Electrically Insulating • Flame Retardant	• Halogen Free • Low (to None) Phosphorus Content	• Medium Stiffness
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA66 GF25 FR(40)		

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.37	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.40	--	%	
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	4.7	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	1.4	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.31E+6	1.06E+6	psi	ISO 527-1/1A/1
Tensile Stress (Break)	19600	15200	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.8	3.5	%	ISO 527-2/1A/5
Flexural Modulus ²	1.29E+6	870000	psi	ISO 178
Flexural Stress ²	31200	23900	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	3.8	--	ft·lb/in ²	
73°F	4.5	6.7	ft·lb/in ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F	27	--	ft·lb/in ²	
73°F	31	36	ft·lb/in ²	

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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	473	--	°F	ISO 75-2/Af
Vicat Softening Temperature	473	--	°F	ISO 306/B50
Melting Temperature ³	500	--	°F	ISO 11357-3
CLTE - Flow (73 to 131°F)	1.3E-5	--	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	5.1E-5	--	in/in/°F	ISO 11359-2
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
Comparative Tracking Index Solution A	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate (0.118 in)	0.0	--	in/min	ISO 3795
Flame Rating				UL 94
0.031 in	V-0	--		
0.06 in	5VA	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.04 in	1760	--	°F	
0.08 in	1760	--	°F	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.04 in	1340	--	°F	
0.08 in	1430	--	°F	

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	0.10	%
Processing (Melt) Temp	536 to 572	°F
Mold Temperature	176 to 212	°F
Injection Rate	Moderate-Fast	

Notes

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

² 0.079 in/min

³ 10°C/min