

Radilon® A HSK 333 BK

Radici Group High Performance Polymers - Polyamide 66

General Information

Product Description

PA66 injection moulding grade. Internally lubricated, fast cycles, easy mould release. Heat stabilized. Black colour.

Suitable for high productivity applications like fasteners, connectors, cable ties.

General

Additive	• Heat Stabilizer
Features	• Fast Molding Cycle • Good Mold Release • Heat Stabilized • Lubricated
Uses	• Automotive Applications • Connectors • Fasteners
Agency Ratings	• EU 2011/65/EC
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA66-T

Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/0.325 kg)	8.0	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 73°F, 0.0787 in)	8.9	%	ISO 62
Water Absorption Equilibrium, 73°F, 0.0787 in, 50% RH	2.1	%	ISO 62
Viscosity Index - Sulfuric Acid	3880	in ³ /lb	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	493000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	12600	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.1	%	ISO 527-2/1A/50
Flexural Modulus ²	464000	psi	ISO 178
Flexural Stress ²	17000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	2.4	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact Strength (73°F)	2.3	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	428	°F	ISO 75-2/Bf
Deflection Temperature Under Load 264 psi, Unannealed	167	°F	ISO 75-2/Af
Vicat Softening Temperature	304	°F	ISO 306/B50
Melting Temperature ³	504	°F	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.031 in)	V-2		UL 94

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Processing Information

Injection	Nominal Value	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	518 to 554	°F
Mold Temperature	158 to 194	°F
Injection Rate	Moderate	

Notes

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

² 0.079 in/min

³ 10°C/min