

Radilon® DT RV330K 3733M BK

Radici Group High Performance Polymers - Polyamide 612

General Information

Product Description

PA612 33% glass fibre reinforced injection moulding grade. Black colour.

Suitable for parts requiring high stiffness and good mechanical properties.

General

Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Features	• High Stiffness
Agency Ratings	• EU 2011/65/EC
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA612-TGF33

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Water Absorption (Saturation, 73°F, 0.0787 in)	2.0	%	ISO 62
Water Absorption Equilibrium, 73°F, 0.0787 in, 50% RH	0.80	%	ISO 62
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	138	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.31E+6	psi	ISO 527-1/1A/1
Tensile Stress (Break)	22800	psi	ISO 527-2/1A/5
Tensile Strain (Break)	4.2	%	ISO 527-2/1A/5
Flexural Modulus ²	1.13E+6	psi	ISO 178
Flexural Stress ²	35500	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	5.2	ft·lb/in ²	
73°F	6.2	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	39	ft·lb/in ²	
73°F	41	ft·lb/in ²	
Notched Izod Impact Strength (73°F)	7.6	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	410	°F	ISO 75-2/Bf
Deflection Temperature Under Load 264 psi, Unannealed	392	°F	ISO 75-2/Af
Melting Temperature ³	421	°F	ISO 11357-3

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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	500 to 554	°F
Mold Temperature	176 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