

RADIFLAM A RV250 HF 100 NAT 1370

*Material code**Colour code*

PROVISIONAL

DESCRIPTION

PA66 flame retardant injection moulding grade, halogen and red phosphorus free. 25% glass fiber reinforced. Natural colour.

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

ISO 1043 : PA66 GF25 FR(40+72)

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80°C, dew point -20°C or below, time 2-4 h or more.

Avoid excessive shear rates and high thermal stresses for better processing. 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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
280 ÷ 300 °C	80 ÷ 100 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet



Underwriters Laboratories Inc. certified material. File number: E116324 www.ul.com

RoHS compliant 2011/65/UE and following amendments

Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE	
				DAM*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m ³	1360	
Moulding shrinkage - Parallel / Normal	280/80/60***	ISO 294-4	%	0,4 / 1	
Moisture absorption 23°C - 50%RH	2mm thk	ISO 62	%	1.3	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	5.5	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	8700	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	135	
Strain at Break	5mm/min	ISO 527-2/1A	%	2,9	
Flexural Modulus	2mm/min	ISO 178	MPa	8500	
Flexural Strength	2mm/min	ISO 178	MPa	210	
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	65	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	260	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	240	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	245	
Flammability Properties					
Flammability	0.8mm	UL 94	class	V0	
Glow Wire Flammability Index	1mm / 2mm	IEC 60695-2-12	°C/mm	960 / 960	
Glow Wire Ignition Temperature	1mm / 2mm	IEC 60695-2-13	°C/mm	725 / 775	
Automotive interior flammability	3.0mm thk	ISO 3795	mm/min	0	
Electrical Properties					
Volume resistivity	500V	IEC 60093	ohm · m	1 E+13	1 E+11
Surface resistivity	500V	IEC 60093	ohm	1 E+12	1 E+10

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]

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