



RADILON A RV150 333 NER

Material code Colour code

DESCRIPTION

PA66 15% glass fiber reinforced injection moulding grade. Black colour.

Suitable for parts requiring improved stiffness.

ISO 1043: PA66 GF15

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature $80 \, ^{\circ}$ C, dew point $-20 \, ^{\circ}$ C or below, time $2-4 \, \text{h}$ or more.

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.

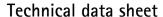
Processing Parameters

Melt Temperature: Mold Temperature: Injection Speed: $280 \div 300 \,^{\circ}\text{C}$ $80 \div 100 \,^{\circ}\text{C}$ Medium

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet RoHS compliant 2011/65/UE and following amendments







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PROPERTY		STANDARD	UNIT	VALUE DAM* Cond**
Physical Properties				
Density Moulding shrinkage – Parallel / Normal Moisture absorption 23°C – 50%RH Water absorption, immersion at 23°C	300/90/60*** 2mm thk 2mm thk	ISO 1183 ISO 294-4 ISO 62 ISO 62	Kg/m ³ % % %	1230 0,4 / 0,9 2.3 7.9
Mechanical Properties				
Tensile Modulus Stress at Break Strain at Break Flexural Modulus Flexural Strength Charpy Impact Strength Charpy Impact Strength Charpy Notched Impact Strength Charpy Notched Impact Strength	1mm/min 5mm/min 5mm/min 2mm/min 2mm/min +23°C -30°C +23°C -30°C	ISO 527-2/1A ISO 527-2/1A ISO 527-2/1A ISO 178 ISO 178 ISO 179/1 eU ISO 179/1 eU ISO 179/1 eA ISO 179/1 eA	MPa MPa % MPa MPa KJ/m² KJ/m² KJ/m²	5800 3900 115 85 2,7 4 5100 170 35 70 30 6 8 5,5
Thermal Properties				
Melting Temperature Heat Deflection Temperature Heat Deflection Temperature Vicat Softening Temperature	10°C/min 1.8 MPa 0.45 MPa 50°C/h	ISO 11357-1-3 ISO 75/2 A f ISO 75/2 B f ISO 306/B50 50N	°C °C °C	260 215 240 245
Flammability Properties				
Flammability Glow Wire Flammability Index Automotive interior flammability	0.8mm 2mm Burn rate	UL 94 IEC 60695-2-1/2 FMVSS302	class °C/mm mm/min	HB 700 0
Electrical Properties				
Volume resistivity Surface resistivity Comparative Tracking Index	500V 500V Sol.A	IEC 60093 IEC 60093 IEC 60112	ohm·m ohm V	1 E+13 1 E+11 1 E+12 1 E+10 550

^{*}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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