Product Information

RADILON A CV300 333 NER

Material code *Colour code*

DESCRIPTION

PA66 30% glass beads filled injection moulding grade. Black colour.

Suitable for parts requiring low warpage and good surface aspect.

ISO 1043 : PA66 GB30

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 ° C, dew point -20 ° C or below, time 2-4 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 ÷ 300 °C	80 ÷ 100 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2002/95/CE and following amendments

Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE DAM*	VALUE Cond**
Physical Properties					
Density		ISO 1183	Kg/m^3	1340	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	1,7	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	7,6	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	4300	2700
Stress at Break	5mm/min	ISO 527-2/1A	MPa	77	40
Strain at Break	5mm/min	ISO 527-2/1A	%	7	10
Flexural Modulus	2mm/min	ISO 178	MPa	3700	
Flexural Strength	2mm/min	ISO 178	MPa	125	
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m^2	25	28
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m^2	3	3,5
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	70	
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	200	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	225	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	
Automotive interior flammability	Burn rate	FMVSS302	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