

RADILON S 35HRD 100 M NAT

Material code Colour code

DESCRIPTION

PA6 medium-high viscosity injection moulding grade. Natural colour.

Suitable for moulding of high thickness items, such as wheels and chairs.
Also fit for gas-assisted injection technology.

ISO 1043 : PA6

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:
250 ÷ 280 °C	70 ÷ 80 °C	Medium

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*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m ³	1140	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	2.9	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	10.2	
Viscosity Index (Sulfuric Acid)		ISO 307	ml/g	205	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2900	1250
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	75	45
Yield Strain	50mm/min	ISO 527-2/1A	%	4	30
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	65	>100
Flexural Modulus	2mm/min	ISO 178	MPa	2500	
Flexural Strength	2mm/min	ISO 178	MPa	100	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	7.7	20
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	5	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	220	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	60	
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	165	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	195	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	
Glow Wire Flammability Index	2mm	IEC 60695-2-1/2	°C/mm	750	
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
Comparative Tracking Index	Sol.A	IEC 60112	V	600	

*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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