

RADIFLAM A RV350 HF 100 NAT

*Material code**Colour code*

DESCRIPTION

PA66 flame retardant injection moulding grade, halogen and red phosphorus free. 35% glass fiber reinforced. Natural colour.

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

ISO 1043 : PA66 GF35 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 2002/95/CE and following amendments

Technical data sheet

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PROPERTY	UNIT	STANDARD	VALUE	
			DAM*	Cond**
Physical Properties				
Density		ISO 1183	Kg/m ³	1470
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	1.3
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	5.4
Mechanical Properties				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	12200 10100
Stress at Break	5mm/min	ISO 527-2/1A	MPa	160 125
Strain at Break	5mm/min	ISO 527-2/1A	%	2,5 2,5
Flexural Modulus	2mm/min	ISO 178	MPa	11700 7400
Flexural Strength	2mm/min	ISO 178	MPa	255 190
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	70 70
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	65
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	12 14
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	12
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	245
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	260
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	250
Flammability Properties				
Flammability	0.8mm	UL 94	class	V0
Glow Wire Flammability Index	1mm / 2mm	IEC 60695-2-1/2	°C/mm	960 / 960
Glow Wire Ignition Temperature	1mm / 2mm	IEC 60695-2-1/3	°C/mm	750 / 775
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	SoI.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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