

PRODUCT INFORMATION

RADILON S RV350W 333 BK

PROVISIONAL

DESCRIPTION

PA6 35% glass fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring high stiffness, good mechanical resistance and excellent heat ageing properties retention.

ISO 1043: PA6-T GF35

THE CHARACTERISTICS SHOWN HERE ARE PROVISIONAL AND REFLECT THE AVERAGE VALUES OF PROPERTIES MEASURED OVER A LIMITED NUMBER OF PRODUCTION CAMPAIGNS

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

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.

Injection Molding Processing Parameters

Melt Temperature
240 - 280°C

Mold Temperature
80 - 90°C

Injection Speed
medium-high

PRODUCT SAFETY AND APPROVALS

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

TECHNICAL DATA SHEET

RADILON S RV350W 333 BK

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density		kg/m ³	1400	
Moulding shrinkage - Parallel / Normal	280 /80 /30 ^[1]	%	0.1 / 0.8	
Water Absorption, immersion at 23°C	2mm	%	6.4	
Moisture Absorption 23°C - 50%RH	2mm	%	1.8	
MECHANICAL PROPERTIES				
Tensile Modulus	1mm/min	MPa	10800	7250
Stress at Break	5mm/min	MPa	177	110
Strain at Break	5mm/min	%	3.1	6
Flexural Modulus	2mm/min	MPa	10000	
Flexural Strength	2mm/min	MPa	270	
Charpy Impact Strength	+23°C	kJ/m ²	95	105
Charpy Notched Impact Strength	+23°C	kJ/m ²	15	30
THERMAL PROPERTIES				
Melting Temperature	10°C/min	°C	220	
Heat Deflection Temperature	1.80 MPa	°C	205	
Heat Deflection Temperature	0.45 MPa	°C	215	
Vicat Softening Temperature	50°C/h 50N	°C	210	
FLAMMABILITY PROPERTIES				
Flammability	0.8mm	UL 94	class	HB
Automotive Interior Flammability	3mm	ISO 3795	mm/min	0
ELECTRICAL PROPERTIES				
Volume Resistivity	500V	IEC 60093	Ohm*m	1E13 1E11
Surface Resistivity	500V	IEC 60093	Ohm	1E12 1E10

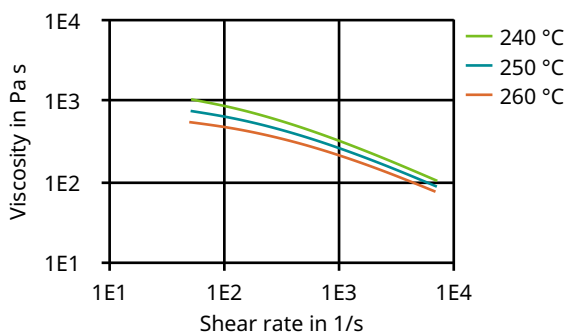
*: DAM = Dry As Moulded state according to ISO 16396-2 **: Cond = Conditioned state similar to ISO 1110 1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]

TECHNICAL DATA SHEET

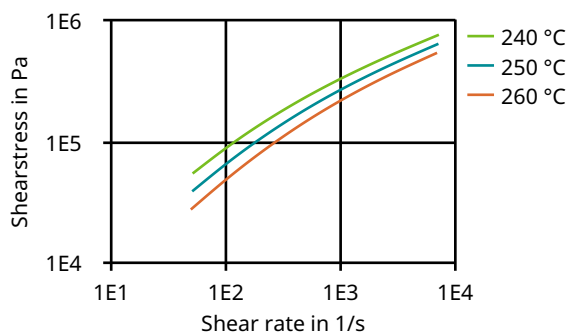
RADILON S RV350W 333 BK

Diagrams

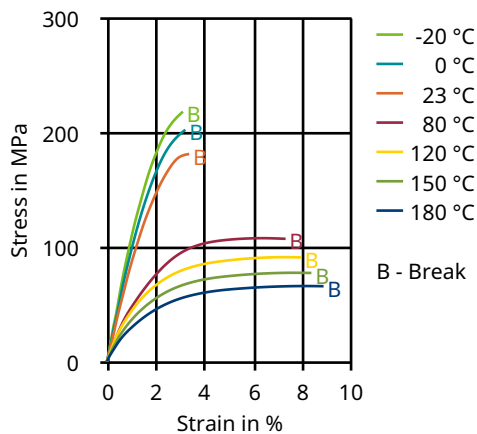
Viscosity-shear rate



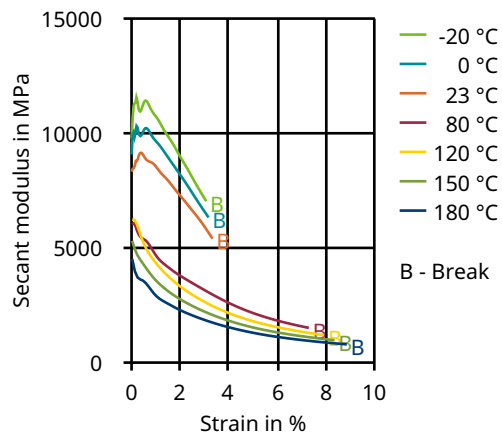
Shearstress-shear rate



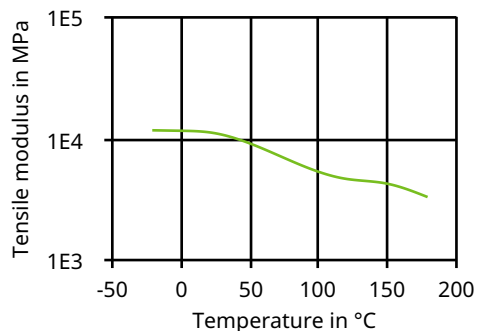
Stress-strain (dry)(->RADILON S RV350W 339 BK)



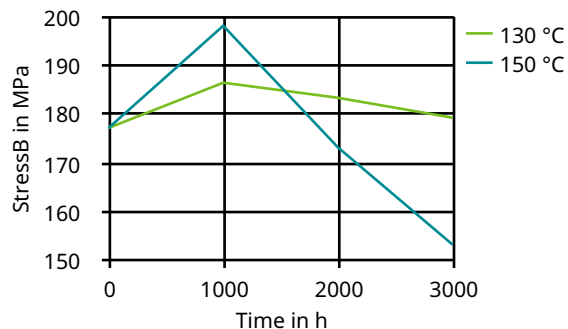
Secant modulus-strain (dry)(->RADILON S RV350W 339 BK)



Tensile modulus-temperature (dry)(->RADILON S RV350W 339 BK)



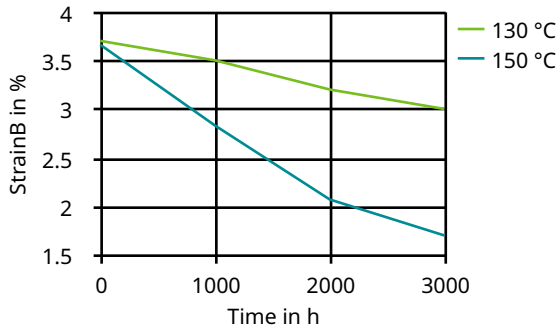
LTHA-Stress at Break 4mm (dry)(->RADILON S RV350W 339 BK)



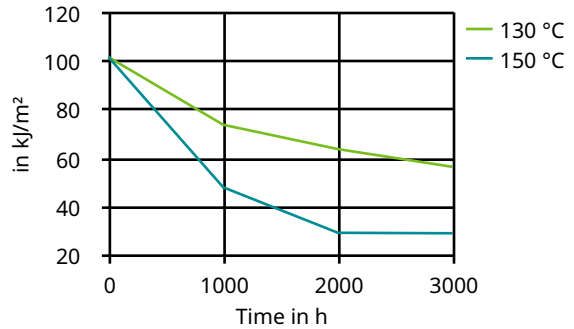
TECHNICAL DATA SHEET

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LTHA-Strain at Break 4mm (dry)



LTHA-Charpy Impact Strength (23°C) 4mm (dry)



LTHA-Charpy Notched Impact Strength (23°C) 4mm (dry)

