



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 Mold Temperature Injection Speed 240 - 280°C 80 - 90°C medium-high

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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TECHNICAL DATA SHEET

RADILON S RV350W 333 BK

PROPERTY		STANDARD	UNIT	VALU	E Cond**
PHYSICAL PROPERTIES					
Density Moulding shrinkage - Parallel / Normal Water Absorption, immersion at 23°C Moisture Absorption 23°C - 50%RH	280 /80 /30 ^[1] 2mm 2mm	ISO 1183 ISO 294-4 ISO 62 ISO 62	kg/m³ % % %	1400 0.1 / 0.8 6.4 1.8	
MECHANICAL PROPERTIES					
Tensile Modulus Stress at Break Strain at Break Flexural Modulus Flexural Strength Charpy Impact Strength Charpy Notched Impact Strength	1mm/min 5mm/min 5mm/min 2mm/min 2mm/min +23°C +23°C	ISO 527-2/1A ISO 527-2/1A ISO 527-2/1A ISO 178 ISO 178 ISO 179/1eU ISO 179/1eA	MPa MPa % MPa MPa kJ/m² kJ/m²	10800 177 3.1 10000 270 95 15	7250 110 6 105 30
THERMAL PROPERTIES					
Melting Temperature Heat Deflection Temperature Heat Deflection Temperature Vicat Softening Temperature	10°C/min 1.80 MPa 0.45 MPa 50°C/h 50N	ISO 11357-1/-3 ISO 75/2Af ISO 75/2Bf ISO 306	°C °C °C	220 205 215 210	
FLAMMABILITY PROPERTIES					
Flammability Automotive Interior Flammability	0.8mm 3mm	UL 94 ISO 3795	class mm/min	HB 0	
ELECTRICAL PROPERTIES					
Volume Resistivity Surface Resistivity	500V 500V	IEC 60093 IEC 60093	Ohm*m Ohm	1E13 1E12	1E11 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]

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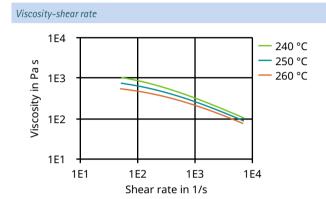




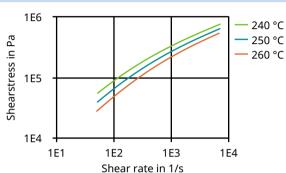
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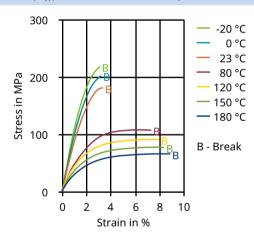
Diagrams



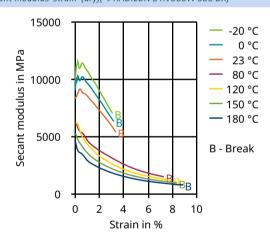
Shearstress-shear rate



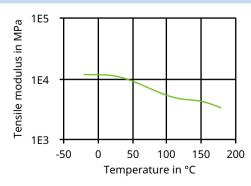
Stress-strain (dry)(->RADILON S RV350W 339 BK)



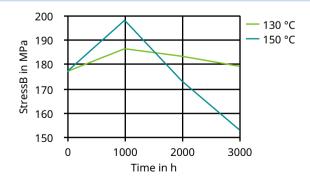
Secant modulus-strain (dry)(->RADILON S RV350W 339 BK)



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



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



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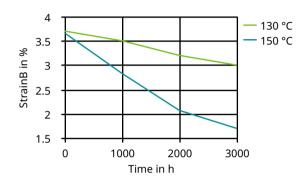




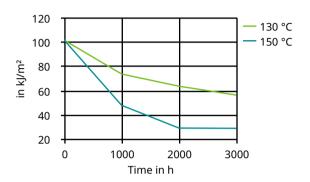
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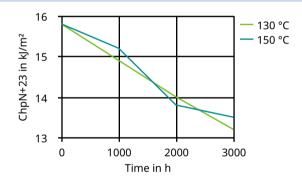
LTHA-Strain at Break 4mm (dry)



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



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



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