Product Information

RADIFLAM S RV250 FR 9054 GRI

Material code *Colour code*

DESCRIPTION

PA6 flame retardant injection moulding grade, halogen and phosphorus free. 25% glass fiber reinforced. Grey colour.

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Low smoke toxicity and optical density. Rated V-0 according to UL-94.

ISO 1043 : PA6 GF25 FR(61)

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:
260 ÷ 290 °C	80 ÷ 90 °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 2011/65/UE 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	1680	
Moulding shrinkage - Parallel / Normal	300/90/60***	ISO 294-4	%	0,3 / 0,6	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	1.1	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	2.5	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	15300	11200
Stress at Break	5mm/min	ISO 527-2/1A	MPa	135	100
Strain at Break	5mm/min	ISO 527-2/1A	%	1.7	1.8
Flexural Modulus	2mm/min	ISO 178	MPa	14500	
Flexural Strength	2mm/min	ISO 178	MPa	200	
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m^2	35	40
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m^2	25	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m^2	4.5	6.5
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m^2	4	
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	200	
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	205	
Thermal Conductivity	23°C	ASTM E1461	W/mK	0.7	
Flammability Properties					
Flammability	1.6mm	UL 94	class	V0	
Glow Wire Flammability Index	1mm / 2mm	IEC 60695-2-12	°C/mm	960 / 960	
Glow Wire Ignition Temperature	1mm / 2mm	IEC 60695-2-13	°C/mm	725 / 725	
Automotive interior flammability	3.0mm thk	ISO 3795	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	-	600	

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]