

PRODUCT INFORMATION

RADIFLAM A RV250 AF 375 BK

DESCRIPTION

PA66 flame retardant injection moulding grade with red phosphorus. 25% glass fiber reinforced. Improved impact properties. Black colour.

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Rated V-0 at 0.75 mm according to UL-94.

ISO 1043: PA66 GF25 FR(52+72)

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 0.10%. 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. The material can not be used to produce parts operating in hot and humid environments (> 70°C / 160°F), or in contact with hot water or overheated steam.

Injection Molding Processing Parameters

Melt Temperature
280 - 300°C

Mold Temperature
80 - 100°C

Injection Speed
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

RADIFLAM A RV250 AF 375 BK

PROPERTY	STANDARD	UNIT	VALUE	DAM*	Cond**
PHYSICAL PROPERTIES					
Density		kg/m ³	1370		
Moulding shrinkage - Parallel / Normal	280 / 80 / 60 ^[1]	%	0.3 / 0.8		
Water Absorption, immersion at 23°C	2mm	%	5.5		
Moisture Absorption 23°C - 50%RH	2mm	%	1.2		
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	MPa	7800		5200
Stress at Break	5mm/min	MPa	120		90
Strain at Break	5mm/min	%	3.1		3.5
Flexural Modulus	2mm/min	MPa	6800		
Flexural Strength	2mm/min	MPa	180		
Charpy Impact Strength	+23°C	kJ/m ²	65		70
Charpy Impact Strength	-30°C	kJ/m ²	60		
Charpy Notched Impact Strength	+23°C	kJ/m ²	13		16
Charpy Notched Impact Strength	-30°C	kJ/m ²	9		
THERMAL PROPERTIES					
Melting Temperature	10°C/min	°C	260		
Heat Deflection Temperature	1.80 MPa	°C	230		
Vicat Softening Temperature	50°C/h 50N	°C	240		
Coeff. of Linear Therm. Expansion	parallel, 23°C-55°C	E-6/K	30		
Coeff. of Linear Therm. Expansion	normal, 23°C-55°C	E-6/K	70		
FLAMMABILITY PROPERTIES					
Flammability	0.8mm	UL 94	class		V-0
Flammability	1.5mm	UL 94	class		5VA
Glow Wire Flammability Index	1mm	IEC 60695-2-1/2	°C		960
Glow Wire Flammability Index	2mm	IEC 60695-2-1/2	°C		960
Glow Wire Ignition Temperature	1mm	IEC 60695-2-1/3	°C		725
Glow Wire Ignition Temperature	2mm	IEC 60695-2-1/3	°C		750
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
Comparative Tracking Index	Sol.A	IEC 60112	-	400	

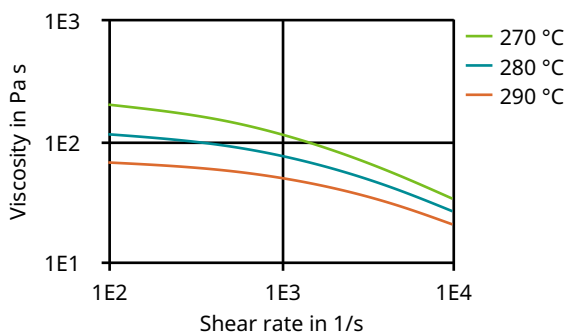
*: DAM = Dry As Moulded state according to ISO 16396-2 **: Cond = Conditioned state similar to ISO 1110 1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]

TECHNICAL DATA SHEET

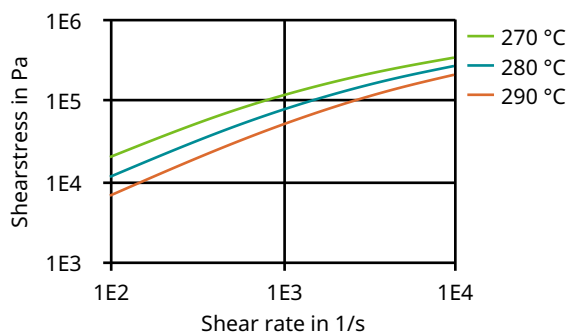
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Diagrams

Viscosity-shear rate (->RADIFLAM A RV250 AF 830 BR)



Shearstress-shear rate (->RADIFLAM A RV250 AF 830 BR)



Specific volume-temperature (pvT) (->RADIFLAM A RV250 AF 830 BR)

