

Radilon® S ERV3904 333 NER

Polyamide 6

Radici Plastics

Message:

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

Suitable for parts requiring high stiffness and mechanical reinforcement.

ISO 1043 : PA6-I GF35

General Information				
Filler / Reinforcement	Glass Fiber,35% Filler by Weight			
Features	Good Toughness			
	High Stiffness			
RoHS Compliance	RoHS Compliant			
UL File Number	E116324			
Appearance	Black			
Processing Method	Injection Molding			
Resin ID (ISO 1043)	PA6-I GF35			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.38	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.40	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	8.0	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	10900	7500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	165	110	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.9	5.0	%	ISO 527-2/1A/5
Flexural Modulus ²	9400	6500	MPa	ISO 178
Flexural Stress ³	250	180	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	10	--	kJ/m ²	
23°C	14	18	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	75	--	kJ/m ²	

23°C	75	85	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	215	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	205	--	°C	ISO 75-2/Af
Vicat Softening Temperature	210	--	°C	ISO 306/B50
Melting Temperature ⁴	220	--	°C	ISO 11357
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+12	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+13	ohms·cm	IEC 60093
Comparative Tracking Index	500	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	0.0	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB	--		UL 94
Glow Wire Flammability Index (2.00 mm)	700	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	725	--	°C	IEC 60695-2-13
Injection	Dry	Unit		
Drying Temperature - Desiccant Dryer	80.0		°C	
Drying Time - Desiccant Dryer	2.0 to 4.0		hr	
Dew Point - Desiccant Dryer	< -20.0		°C	
Suggested Max Moisture	0.15		%	
Processing (Melt) Temp	240 to 280		°C	
Mold Temperature	80.0 to 90.0		°C	
Injection Rate	Moderate-Fast			
NOTE				

1. 280°C Melt Temp / 80°C
Mold Temp / 30 Mpa
Cavity press

2. 2.0 mm/min

3. 2.0 mm/min

4. 10°C/min

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