

Radilon® S 38F 100 NAT

Polyamide 6

Radici Plastics

Message:

PA6 high viscosity extrusion grade. Natural colour.

Suitable for extrusion of cast and blown films, and monofilaments.

ISO 1043 : PA6

General Information				
Features	High Viscosity			
Uses	Blown Film			
	Cast Film			
	Monofilaments			
RoHS Compliance	RoHS Compliant			
Appearance	Natural Color			
Processing Method	Extrusion			
	Injection Molding			
Resin ID (ISO 1043)	PA6			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	11	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	3.1	--	%	
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	240	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2900	1100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	75.0	40.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	30	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	90	> 100	%	ISO 527-2/1A/50
Flexural Modulus ¹	2500	750	MPa	ISO 178
Flexural Stress ²	95.0	30.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	5.0	--	kJ/m ²	
23°C	8.0	20	kJ/m ²	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	170	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	200	--	°C	ISO 306/B50
Melting Temperature ³	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	600	--	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				IEC 60695-2-12
1.00 mm	850	--	°C	
2.00 mm	825	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
1.00 mm	875	--	°C	
2.00 mm	700	--	°C	
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	250 to 280		°C	
Mold Temperature	70.0 to 80.0		°C	
Injection Rate	Moderate			
Extrusion	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	2.0 to 4.0		hr	
Suggested Max Moisture	0.15		%	
Melt Temperature	240 to 270		°C	
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			
3.	10°C/min			

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