

Radilon® A ESL128 333 NER

Polyamide 66

Radici Plastics

Message:

PA66 injection moulding grade. Toughened. Black colour.

Suitable for parts requiring good impact strength.

ISO 1043 : PA66-HI

General Information				
UL YellowCard		E148796-101473249	E195505-101510654	E337835-101516844
		E195508-101520646		
Features		Good Impact Resistance		
RoHS Compliance		RoHS Compliant		
Appearance		Black		
Processing Method		Injection Molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Resin ID (ISO 1043)		PA66-HI		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.11	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	1.7	--	%	
Flow	2.7	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	7.6	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2050	1300	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	55.0	35.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	30	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	50	> 50	%	ISO 527-2/1A/50
Flexural Modulus ²	1900	--	MPa	ISO 178
Flexural Stress ³	75.0	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	17	18	kJ/m ²	
23°C	65	110	kJ/m ²	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	140	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	210	--	°C	ISO 306/B50
Melting Temperature ⁴	260	--	°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	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	< 30	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB	--		UL 94
Glow Wire Flammability Index (2.00 mm)	650	--	°C	IEC 60695-2-12
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	270 to 290		°C	
Mold Temperature	70.0 to 90.0		°C	
Injection Rate	Moderate			
NOTE				
1.	290°C Melt Temp / 70°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

