

Radiflam® S RV250FR 339 E NER

Polyamide 6

Radici Plastics

Message:

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

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Low smoke toxicity and optical density.

Applications in underground railway sector. Rated V-0 according to UL-94.

ISO 1043 : PA6 GF25 FR(61)

General Information				
UL YellowCard		E148796-101473247	E195505-101510652	E337835-101516842
		E195508-101520644		
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Flame Retardant		
Features		Flame Retardant		
		Halogen Free		
		Low (to None) Phosphorus Content		
		Low Optical Density		
		Low Toxicity		
RoHS Compliance		RoHS Compliant		
UL File Number		E116324		
Appearance		Black		
Processing Method		Injection Molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
Resin ID (ISO 1043)		PA6 GF25 FR(61)		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.68	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	2.5	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	1.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	14500	11000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	140	105	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.8	1.9	%	ISO 527-2/1A/5
Flexural Modulus ¹	14000	--	MPa	ISO 178
Flexural Stress ²	220	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

-30°C	4.0	--	kJ/m ²	
23°C	4.5	6.5	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	25	--	kJ/m ²	
23°C	35	40	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	200	--	°C	ISO 75-2/Af
Vicat Softening Temperature	205	--	°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	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	0.0	--	mm/min	FMVSS 302
Flame Rating (1.60 mm)	V-0	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
1.00 mm	960	--	°C	
2.00 mm	960	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
1.00 mm	725	--	°C	
2.00 mm	725	--	°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	0.10		%	
Processing (Melt) Temp	260 to 290		°C	
Mold Temperature	80.0 to 90.0		°C	
Injection Rate	Moderate-Fast			
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			
3.	10°C/min			

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