

Radilon® S 24E 100 NAT

Polyamide 6

Radici Plastics

Message:

PA6 low viscosity extrusion and injection moulding grade. Natural colour.

Suitable for parts which require low material viscosity for efficient processing. Material specifically developed for fuel filter media.

ISO 1043 : PA6

General Information				
Features		Good Processability		
		Low Viscosity		
Uses		Fuel Lines		
RoHS Compliance		RoHS Compliant		
Appearance		Natural Color		
Processing Method		Extrusion		
		Injection Molding		
Resin ID (ISO 1043)		PA6		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.41	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	11	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.7	--	%	
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	125	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	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	70	> 50	%	ISO 527-2/1A/50
Flexural Modulus ¹	2600	750	MPa	ISO 178
Flexural Stress ²	100	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	--	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	55.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	195	--	°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)	V-2	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
1.00 mm	750	--	°C	
2.00 mm	800	--	°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	240 to 270		°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 260		°C	
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			
3.	10°C/min			

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