

Radilon® S 35VHS 338 E NER

Polyamide 6

Radici Plastics

Message:

PA6 medium-high viscosity injection moulding grade. Lubricated. Black colour.

Suitable for parts with medium-high wall thickness.

ISO 1043 : PA6

General Information				
Additive	Lubricant			
Features	Lubricated			
	Medium-high Viscosity			
Uses	Thick-walled Parts			
RoHS Compliance	RoHS Compliant			
Appearance	Black			
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	10	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.9	--	%	
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	205	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3000	--	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	77.0	--	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	--	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	75	--	%	ISO 527-2/1A/50
Flexural Modulus ¹	2600	--	MPa	ISO 178
Flexural Stress ²	105	--	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	6.0	--	kJ/m ²	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	190	--	°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 (2.00 mm)	750	--	°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	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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