

Radilon® A HS 164 NAT

Polyamide 66

Radici Plastics

Message:

PA66 injection moulding grade. Internally lubricated. Fast cycling. Natural colour.

General purpose grade, suitable for parts requiring high productivity like fasteners, connectors, cable ties.

ISO 1043 : PA66

General Information				
Features	Fast Molding Cycle			
	General Purpose			
	Lubricated			
Uses	Connectors			
	Fasteners			
	Wire & Cable Applications			
RoHS Compliance	RoHS Compliant			
UL File Number	E116324			
Appearance	Natural Color			
Processing Method	Injection Molding			
Resin ID (ISO 1043)	PA66			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	1.9	--	%	
Flow	1.8	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	8.9	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	1300	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	85.0	55.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	30	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	> 50	%	ISO 527-2/1A/50
Flexural Modulus ²	2900	--	MPa	ISO 178
Flexural Stress ³	110	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method

Charpy Notched Impact Strength				ISO 179/1eA
-30°C	4.5	--	kJ/m ²	
23°C	6.0	15	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)				ISO 179/1eU
No Break		--		
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	200	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	70.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	240	--	°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	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	0.0	--	mm/min	FMVSS 302
Flame Rating				UL 94
0.400 mm	V-2	--		
0.800 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
1.00 mm	750	--	°C	
2.00 mm	800	--	°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	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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