

Radilon® S USX270 333 NER

Polyamide 6

Radici Plastics

Message:

PA6 extrusion grade. Toughened. Black colour.

Suitable for extrusion of parts requiring excellent impact resistance and very high flexibility.

ISO 1043 : PA6-HI

General Information				
Features		Good Flexibility Good Toughness High Impact Resistance		
RoHS Compliance		RoHS Compliant		
Appearance		Black		
Processing Method		Extrusion Injection Molding		
Resin ID (ISO 1043)		PA6-HI		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.11	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	7.0	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	1.8	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1300	600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	35.0	20.0	MPa	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 100	> 100	%	ISO 527-2/1A/50
Flexural Modulus ¹	1200	500	MPa	ISO 178
Flexural Stress ²	40.0	18.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	30	--	kJ/m ²	
23°C	70	120	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	80.0	--	°C	ISO 75-2/Bf

1.8 MPa, Unannealed	50.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	105	--	°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	500	--	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
Glow Wire Ignition Temperature (2.00 mm)	675	--	°C	IEC 60695-2-13
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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