RADILON A RV330K 1700 NT

DESCRIPTION

PA66 33% glass fiber reinforced injection molding grade. Heat stabilized. Natural color.

Suitable for parts requiring medium stiffness, good mechanical resistance and good heat ageing properties retention.

ISO 1043: PA66-GF33

REGIONAL AVAILABILITY: North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Formerly Known As N66G33HRL.XN1162.NAT and RN66G33H.NAT

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Injection Molding Processing Parameters

Melt Temperature	Mold Temperature	Injection Speed
280 - 300°C	80 - 100°C	medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet
Underwriters Laboratories Inc. certified material www.ul.com
ROHS compliant 2011/65/EU and following amendments

The information provided in this documentation corresponds to our knowledge on the subject as of date of publication. This information may be subject to revision as new knowledge and experience become available. The data provided reflects the average values of the properties measured over an adequate number of different production cycles and relates only to the designated material; this data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits nor used alone as the basis of design; it is not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since the mentioned companies cannot anticipate all variations in actual end-use conditions, they make no warranties and assume no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe, any patent rights.
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PROPERTY		STANDARD	UNIT	VALUE DAM*	VALUE Cond**
PHYSICAL PROPERTIES					
Density		ISO 1183	kg/m³	1400	-
Moulding shrinkage - Parallel / Normal	300 /90 /60 [1]	ISO 294-4	%	0.3	1.0
Water Absorption, immersion at 23°C	2mm	ISO 62	%	5.5	
Moisture Absorption 23°C - 50%RH	2mm	ISO 62	%	1.5	
Viscosity Index (Sulfuric Acid)		ISO 307	ml/g	140	
MECHANICAL PROPERTIES					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	11000	-
Stress at Break	5mm/min	ISO 527-2/1A	MPa	200	-
Strain at Break	5mm/min	ISO 527-2/1A	%	3.3	-
Flexural Modulus	2mm/min	ISO 178	MPa	9800	-
Flexural Strength	2mm/min	ISO 178	MPa	200	-
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m²	75	-
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m²	13.5	-
Izod Notched Impact Strength	+23°C	ISO 180/1A	kJ/m²	13	-
THERMAL PROPERTIES					
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	262	
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	245	
Heat Deflection Temperature	0.45 MPa	ISO 75/2Bf	°C	255	
Vicat Softening Temperature	50°C/h 50N	ISO 306	°C	250	
FLAMMABILITY PROPERTIES					
Flammability	0.8mm	UL 94	class	HB	
Glow Wire Flammability Index	2mm	IEC 60695-2-12	°C	700	

*: DAM = Dry As Moulded state according to ISO 16396-2 , **: Cond = Conditioned state similar to ISO 1110

1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]

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