

Radilon® S HS 105 M NAT

Polyamide 6

Radici Plastics

Message:

PA6 injection moulding grade. Nucleated, fast cycling. Natural colour.

General purpose grade, suitable for parts requiring high productivity.

ISO 1043 : PA6

General Information				
UL YellowCard	E195505-101510677	E337835-101516867	E195508-101520669	
Additive	Nucleating Agent			
Features	Fast Molding Cycle			
	General Purpose			
	Nucleated			
RoHS Compliance	RoHS Compliant			
UL File Number	E116324			
Appearance	Natural Color			
Processing Method	Injection Molding			
Resin ID (ISO 1043)	PA6			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.90	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	11	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.7	--	%	
Viscosity Number (H2SO4 (Sulphuric Acid))	140	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	1200	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	80.0	45.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	30	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	> 50	%	ISO 527-2/1A/50
Flexural Modulus ²	2600	--	MPa	ISO 178
Flexural Stress ³	100	--	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	7.5	13	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	170	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	190	--	°C	ISO 306/B50
Melting Temperature ⁴	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
	750			
Glow Wire Flammability Index (1.00 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			
NOTE				
1.	270°C Melt Temp / 60°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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