

Radiflam® A FR 308 NER

Polyamide 66

Radici Plastics

Message:

PA66 flame retardant injection moulding grade. Halogen and phosphorus free. Black colour.

Suitable for parts where fire retardancy is required. Rated V-0 at 0.4 mm according to UL-94.

Also suitable for monofilament extrusion.

ISO 1043 : PA66 FR(30)

General Information				
Additive	Flame Retardant			
Features	Flame Retardant			
	Halogen Free			
	Low (to None) Phosphorus Content			
RoHS Compliance	RoHS Compliant			
UL File Number	E116324			
Appearance	Black			
Processing Method	Filament Extrusion			
	Injection Molding			
Resin ID (ISO 1043)	PA66 FR(30)			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.17	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	1.4	--	%	
Flow	1.4	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	7.7	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	1.8	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3500	2550	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	75.0	50.0	MPa	ISO 527-2/1A/50
Nominal Tensile Strain at Break	5.0	> 50	%	ISO 527-2/1A/50
Flexural Modulus ²	3300	--	MPa	ISO 178
Flexural Stress ³	115	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

-30°C	3.5	--	kJ/m ²	
23°C	4.5	6.0	kJ/m ²	
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	220	--	°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-0	--		
0.800 mm	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
1.00 mm	960	--	°C	
2.00 mm	960	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
1.00 mm	> 775	--	°C	
2.00 mm	> 750	--	°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	0.10		%	
Processing (Melt) Temp	270 to 290		°C	
Mold Temperature	60.0 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	0.10		%	
Melt Temperature	270 to 290		°C	
NOTE				

1.	280°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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