

Radilon® S ERV3808 100 NAT

Polyamide 6

Radici Plastics

Message:

PA6 30% glass fiber reinforced injection moulding grade. Toughened. Natural colour.

Suitable for parts requiring improved impact strength along with high stiffness and mechanical reinforcement.

ISO 1043 : PA6-I GF30

General Information				
UL YellowCard		E148796-101473254	E195505-101510659	E337835-101516849
		E195508-101520651		
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Features		Good Toughness		
		High Stiffness		
RoHS Compliance		RoHS Compliant		
Appearance		Natural Color		
Processing Method		Injection Molding		
Resin ID (ISO 1043)		PA6-I GF30		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.27	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	0.50	--	%	
Flow	1.1	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	8.6	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.2	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8500	5700	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	145	85.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	5.0	%	ISO 527-2/1A/5
Flexural Modulus ²	7650	--	MPa	ISO 178
Flexural Stress ³	220	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	15	--	kJ/m ²	
23°C	24	35	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU

-30°C	85	--	kJ/m ²	
23°C	80	90	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	205	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	200	--	°C	ISO 75-2/Af
Vicat Softening Temperature	205	--	°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)	HB	--		UL 94
Glow Wire Flammability Index (2.00 mm)	650	--	°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	240 to 280		°C	
Mold Temperature	80.0 to 90.0		°C	
Injection Rate	Moderate-Fast			
NOTE				
1.	280°C Melt Temp / 80°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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