

Radilon® S HSX 100 NAT

Polyamide 6

Radici Plastics

Message:

PA6 injection moulding grade. Toughened. Natural colour.

Suitable for parts requiring improved impact resistance.

ISO 1043 : PA6-I

General Information				
Features		Good Impact Resistance		
		Good Toughness		
RoHS Compliance		RoHS Compliant		
Appearance		Natural Color		
Processing Method		Injection Molding		
Resin ID (ISO 1043)		PA6-I		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.11	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Across Flow	2.0	--	%	
Flow	1.9	--	%	
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	9.2	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.7	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2500	1050	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	65.0	40.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.2	20	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	55	> 100	%	ISO 527-2/1A/50
Flexural Modulus ²	2300	--	MPa	ISO 178
Flexural Stress ³	90.0	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	10	--	kJ/m ²	
23°C	15	--	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, Unannealed	160	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	55.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	185	--	°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	< 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
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	260 to 290		°C	
Mold Temperature	70.0 to 80.0		°C	
Injection Rate	Moderate			
NOTE				
1.	290°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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