RADIFLAM A FR 122 NT

PA66 RadiciGroup High Performance Polymers

Product Texts

PA66 flame retardant injection moulding grade. Halogen and phosphorus free. High flowability. Natural colour.

Suitable for parts where fire retardancy is required, particularly for thin-walled items or with long flow paths. Rated V-0 at 0.4 mm according to UL-94.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
[C] Molding shrinkage, parallel	**1.1 / ***	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**1.1 / ***	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**3700 / -**	MPa	ISO 527
[C] Yield stress	**90 / -**	MPa	ISO 527
[C] Yield strain	**4 / -**	%	ISO 527
[C] Nominal strain at break	**6 / -**	%	ISO 527
[C] Charpy notched impact strength, +23°C	**3.5 / -**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**260 / ***	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**80 / ***	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**200 / ***	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**220 / ***	°C	ISO 306
[C] Burning Behav. at thickness h	**V-0 / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-
Yellow Card available	**yes / ***	-	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Volume resistivity	**1E13 / 1E11**	Ohm*m	IEC 62631-3-1
[C] Surface resistivity	*** / 1E10**	Ohm	IEC 62631-3-2
[C] Electric strength	**31 / 26**	kV/mm	IEC 60243-1
[C] Comparative tracking index	**600 / -**	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**7.7 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**1.8 / ***	%	Sim. to ISO 62
[C] Density	**1180 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Processing humidity	**≤0.1**	%	-
Melt temperature	**270 - 290**	°C	-
Mold temperature	**60 - 80**	°C	-

Characteristics

Processing
Injection Molding, Other Extrusion

Delivery form
Granules, Natural Color

Additives
Release agent

Special Characteristics
Flame retardant, Halogen-free, Phosphorus-free, Heat stabilized or stable to heat

Regional Availability
North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Other text information

Injection molding
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
270 - 290°C	60 - 80°C	medium

Extrusion Temperature
270 - 290°C