

RADISTRONG A RV600W 333 BK

(PA66+PA*)-GF60

RadiciGroup High Performance Polymers

Product Texts

Special PA 60% glass fibre reinforced, injection moulding grade. Heat stabilized. Black colour

Product with enhanced mechanical properties, suitable for demanding applications as in case of metal replacement.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.1 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.3 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	22400 / 17600	MPa	ISO 527
^[C] Stress at break	270 / 200	MPa	ISO 527
^[C] Strain at break	2.2 / 2.4	%	ISO 527
^[C] Charpy impact strength, +23°C	95 / 105	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	85 / 95	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	17 / 18	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	15 / 16	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	255 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	245 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	13 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	73 / *	E-6/K	ISO 11359-1/-2
Yellow Card available	yes / *	-	-
^[C] Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[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]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	3.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	0.8 / *	%	Sim. to ISO 62
^[C] Density	1730 / -	kg/m ³	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	≤0.15	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	90 - 120	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

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Delivery form

Granules, Black

Regional Availability

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

Additives

Release agent

Other text information

Injection molding

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. 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

280 - 300°C

Mold Temperature

90 - 120°C

Injection Speed

medium-high