

PRODUCT INFORMATION

RADILON S CF100W 333 BK

Material code Colour code

PROVISIONAL

DESCRIPTION

PA6 10% carbon fiber reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts and components requiring high mechanical properties.
The presence of carbon fibers also provides higher electrical and thermal conductivity.

ISO 1043 : PA6-T CF10

MATERIAL HANDLING AND PROCESSING

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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
240 ÷ 280 °C	80 ÷ 90 °C	Medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2011/65/UE and following amendments

Issued: 12/09/2017

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TECHNICAL DATA SHEET

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PROPERTY	UNIT	STANDARD	VALUE	
			DAM*	Cond**
<i>Physical Properties</i>				
Density		ISO 1183	Kg/m ³	1170
<i>Mechanical Properties</i>				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	9500 6500
Stress at Break	5mm/min	ISO 527-2/1A	MPa	175 105
Strain at Break	5mm/min	ISO 527-2/1A	%	3
Flexural Modulus	2mm/min	ISO 178	MPa	8500 4700
Flexural Strength	2mm/min	ISO 178	MPa	235 130
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	40 60
Charpy Impact Strength	-30°C	ISO 179/1 eU	KJ/m ²	40
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	5,5 12,5
Charpy Notched Impact Strength	-30°C	ISO 179/1 eA	KJ/m ²	5
<i>Thermal Properties</i>				
Melting Temperature	10°C/min	ISO 11357-1-3	°C	220
Heat Deflection Temperature	1.8 MPa	ISO 75/2Af	°C	205
<i>Flammability Properties</i>				
Flammability	0.8mm	UL 94	class	HB

The characteristics shown here must be considered purely provisional and indicative for a product at developmental stage.

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]

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