

# RADILON S NAT GF015L

## DESCRIPTION

PA6 15% glass fiber reinforced injection moulding grade. Natural colour.

ISO 1043 : PA6 GF15

## 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 2002/95/CE and following amendments

## Technical data sheet

# RADILON S NAT GF015L

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>Physical Properties</b>				
Density	ISO 1183	Kg/m <sup>3</sup>	1230	
<b>Mechanical Properties</b>				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	6500
Stress at Break	5mm/min	ISO 527-2/1A	MPa	130
Strain at Break	5mm/min	ISO 527-2/1A	%	3,5
Flexural Modulus	2mm/min	ISO 178	MPa	5500
Flexural Strength	2mm/min	ISO 178	MPa	185
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m <sup>2</sup>	35
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m <sup>2</sup>	7
<b>Thermal Properties</b>				
Melting Temperature	10°C/min	ISO 11357-1-3	°C	220
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	195

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