

# RADILON S NER GF015L

## DESCRIPTION

PA6 15% glass fibre reinforced injection moulding grade. Black colour.

ISO 1043: PA6 GF15

REGIONAL AVAILABILITY: Europe

## MATERIAL HANDLING AND PROCESSING

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  
240 - 280°C

Mold Temperature  
80 - 90°C

Injection Speed  
medium-high

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet  
ROHS compliant 2011/65/EU and following amendments

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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>PHYSICAL PROPERTIES</b>				
Density	ISO 1183	kg/m <sup>3</sup>	1240	
<b>MECHANICAL PROPERTIES</b>				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	6000
Stress at Break	5mm/min	ISO 527-2/1A	MPa	115
Strain at Break	5mm/min	ISO 527-2/1A	%	2.8
Flexural Modulus	2mm/min	ISO 178	MPa	5000
Flexural Strength	2mm/min	ISO 178	MPa	180
Charpy Impact Strength	+23°C	ISO 179/1eU	kJ/m <sup>2</sup>	30
Charpy Notched Impact Strength	+23°C	ISO 179/1eA	kJ/m <sup>2</sup>	5.5
<b>THERMAL PROPERTIES</b>				
Melting Temperature	10°C/min	ISO 11357-1/-3	°C	220
Heat Deflection Temperature	1.80 MPa	ISO 75/2Af	°C	180

\*: DAM = Dry As Moulded state according to ISO 16396-2, \*\*: Cond = Conditioned state similar to ISO 1110