

Radel® R-5000

polyphenylsulfone

Radel R-5000 is a transparent polyphenylsulfone (PPSU) which offers exceptional hydrolytic stability, and toughness superior to other commercially-available, high-temperature engineering resins. This resin also offer high deflection temperatures and outstanding resistance to environmental stress cracking. Radel polymers are inherently flame retardant,

provide excellent thermal stability and possess good electrical properties.

- Clear: Radel R-5000 CL 301
- Natural: Radel R-5000 NT

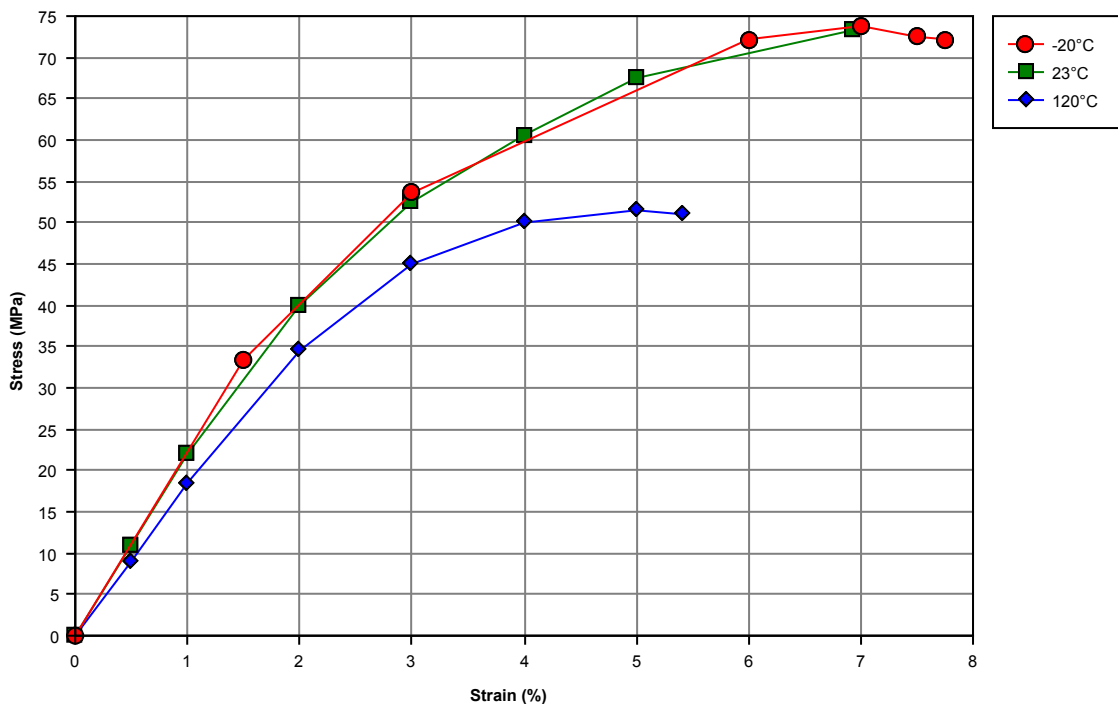
General

Material Status	• Commercial: Active		
Availability	• Asia Pacific • Europe	• North America • South America	
Features	• Acid Resistant • Autoclave Sterilizable • Base Resistant • Biocompatible • Detergent Resistant • E-beam Sterilizable • Ethylene Oxide Sterilizable • Flame Retardant • General Purpose	• Good Chemical Resistance • Good Dimensional Stability • Good Electrical Properties • Good Sterilizability • Good Thermal Aging Resistance • Good Thermal Stability • Heat Sterilizable • High ESCR (Stress Crack Resist.) • High Heat Resistance	• Hydrolytically Stable • Radiation (Gamma) Resistant • Radiation Sterilizable • Radiotranslucent • Steam Resistant • Steam Sterilizable • Ultra High Toughness
Uses	• Automotive Applications • Dental Applications • Food Service Applications	• Hospital Goods • Medical Appliances • Medical/Healthcare Applications	• Membranes • Surgical Instruments
Agency Ratings	• FAA FAR 25.853a • ISO 10993	• NSF 51 ¹ • NSF 61 ²	
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• ASTM D6394 SP0312		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Blow Molding • Extrusion • Film Extrusion	• Injection Molding • Machining • Profile Extrusion	• Sheet Extrusion • Thermoforming

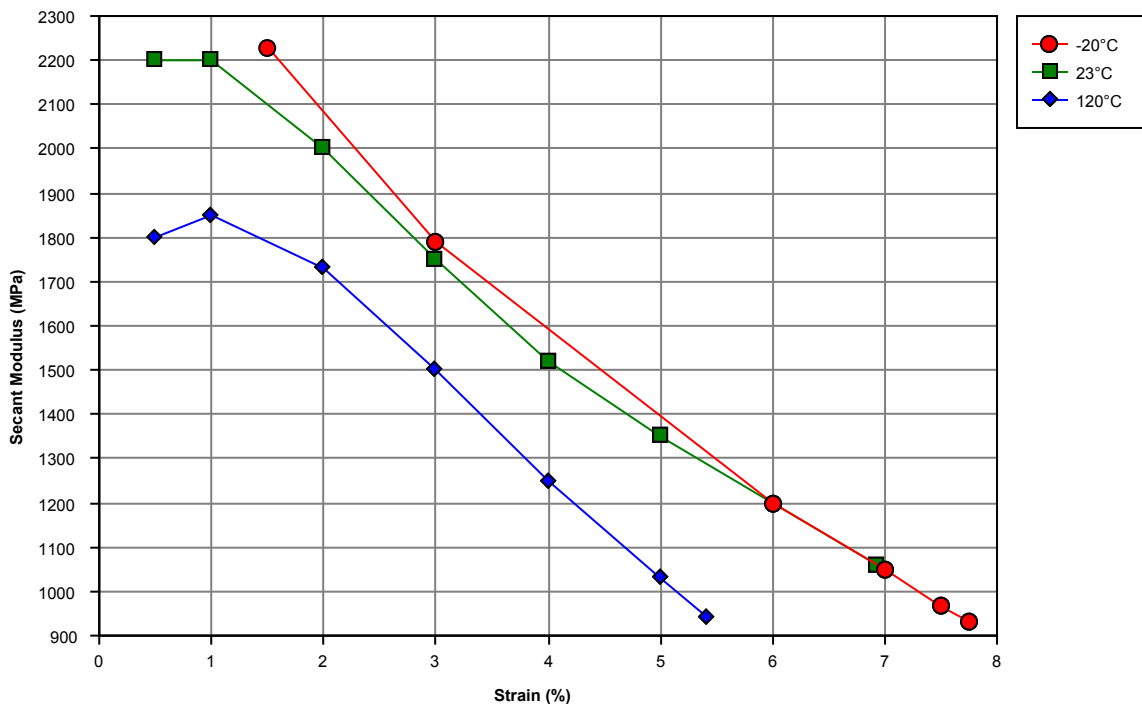
Physical	Typical Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	14 to 20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption			ASTM D570
24 hr	0.37	%	
Equilibrium	1.1	%	
Mechanical	Typical Value	Unit	Test Method
Tensile Modulus (3.18 mm)	2340	MPa	ASTM D638
Tensile Strength (3.18 mm)	69.6	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield, 3.18 mm	7.2	%	
Break, 3.18 mm	60 to 120	%	

Mechanical	Typical Value	Unit	Test Method
Flexural Modulus (3.18 mm)	2410	MPa	ASTM D790
Flexural Strength (5.0% Strain, 3.18 mm)	91.0	MPa	ASTM D790
Impact	Typical Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	690	J/m	ASTM D256
Tensile Impact Strength (3.18 mm)	399	kJ/m ²	ASTM D1822
Thermal	Typical Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed, 3.18 mm	207	°C	ASTM D648
Glass Transition Temperature	220	°C	ASTM E1356
CLTE - Flow (3.18 mm)	0.000056	cm/cm/°C	ASTM D696
Electrical	Typical Value	Unit	Test Method
Volume Resistivity	9.0E+15	ohm·cm	ASTM D257
Dielectric Strength			ASTM D149
0.0254 mm	> 200	kV/mm	
3.18 mm	15	kV/mm	
Dielectric Constant (3.18 mm, 60 Hz)	3.44		ASTM D150
Flammability	Typical Value	Unit	Test Method
Flame Rating ³ (0.762 mm)	V-0		UL 94
Optical	Typical Value	Unit	Test Method
Refractive Index	1.672		ASTM D542
Additional Information	Typical Value	Unit	Test Method
Steam Sterilization - w/ Morpholine ⁴	> 1000	Cycles	No Standard
Injection	Typical Value	Unit	
Drying Temperature	149	°C	
Drying Time	2.5	hr	
Processing (Melt) Temp	360 to 391	°C	
Mold Temperature	138 to 163	°C	
Screw Compression Ratio	2.2:1.0		
Extrusion	Typical Value	Unit	
Drying Temperature	171	°C	
Drying Time	4.0	hr	
Cylinder Zone 1 Temp.	338 to 388	°C	
Cylinder Zone 2 Temp.	338 to 388	°C	
Cylinder Zone 3 Temp.	338 to 388	°C	
Cylinder Zone 4 Temp.	338 to 388	°C	
Cylinder Zone 5 Temp.	338 to 388	°C	
Adapter Temperature	327 to 371	°C	
Melt Temperature	343 to 399	°C	
Die Temperature	327 to 371	°C	

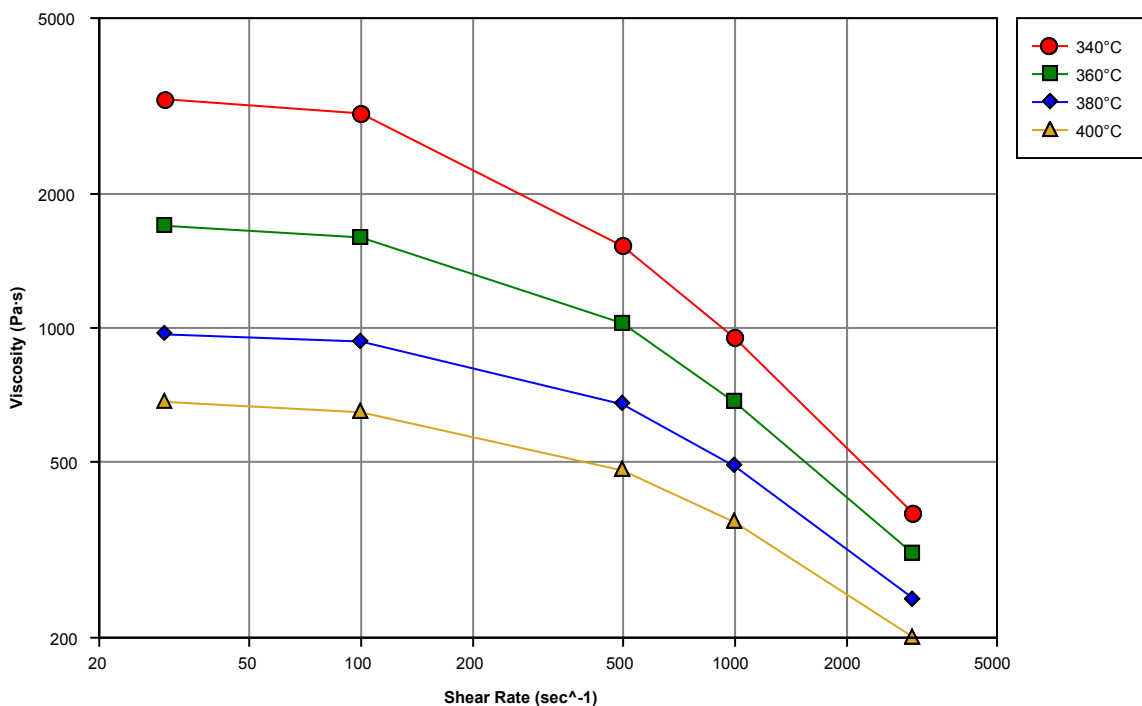
Isothermal Stress vs. Strain (ISO 11403-1)



Secant Modulus vs. Strain (ISO 11403-1)



Viscosity vs. Shear Rate (ISO 11403-2)



Notes

Typical properties: these are not to be construed as specifications.

¹ Maximum Temperature of Use: 190°C (375°F)

² Tested at 82 °C (180 °F) (Commercial Hot)

³ These flammability ratings are not intended to reflect hazards presented by these or any other materials under actual fire conditions.

⁴ Cycles passed without cracking, crazing, or rupture.

Steam Autoclave Conditions:

- Temperature: 270°F (132°C)
- Time: 30 minutes/cycle
- Steam Pressure: 27 psig (0.19 MPa)
- Stress Level: 1000 psi (7.0 MPa) in flexure
- Additive: Morpholine at 50 ppm

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