

Starflam PX06009

Polyamide 6

Eurostar Engineering Plastics

Message:

Starflam PX06009 is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced Polyamide 6 Injection Molding Resin

General Information			
UL YellowCard	E340012-100750133		
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
	Low (to None) Phosphorus Content		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.70 to 0.90	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6200	MPa	ISO 527-2/1
Tensile Stress (Break)	95.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.2	%	ISO 527-2/5
Flexural Modulus ¹	6200	MPa	ISO 178
Flexural Stress	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	5.0	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	45	kJ/m²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Annealed)	185	°C	ISO 75-2/Ae
RTI Imp	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	

Rear Temperature	240 to 250	°C
Middle Temperature	250 to 260	°C
Front Temperature	250 to 270	°C
Processing (Melt) Temp	250 to 270	°C
Mold Temperature	50.0 to 90.0	°C

NOTE		
1.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	4 hr, 80°C	

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