

Staramide PFB42ES

Polyamide 6

Eurostar Engineering Plastics

Message:

Staramide PFB42ES is Glass Bead and Glass Fiber Reinforced Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Bead\Glass Fiber		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.44	%	Internal Method
Water Absorption (23°C, 24 hr)	1.9	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5700	MPa	ISO 527-2/1
Tensile Stress (Break)	93.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.6	%	ISO 527-2/5
Flexural Modulus ¹	4700	MPa	ISO 178
Flexural Stress	145	MPa	ISO 178
Flexural Strain at Break ²	4.4	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	20	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed, 64.0 mm Span)	156	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.9E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			

1.	2.0 mm/min
2.	2.0 mm/min
3.	80*10*4
4.	80*10*4
5.	80*10*4

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