

Starflam PX05004

Polyamide 66/6 Copolymer
Eurostar Engineering Plastics

Message:

Starflam PX05004 is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced, Polyamide 66 and Polyamide 6 Injection Molding Resin

General Information			
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	1.34	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.40 to 0.60	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5700	MPa	ISO 527-2/1
Tensile Stress (Yield)	84.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.2	%	ISO 527-2/5
Flexural Modulus ¹	5300	MPa	ISO 178
Flexural Stress	147	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	185	°C	ISO 75-2/Af
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	> 500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Tested by E2P)	V-2		UL 94
Glow Wire Flammability Index (0.800 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	255 to 265	°C	

Middle Temperature	260 to 270	°C
Front Temperature	260 to 270	°C
Processing (Melt) Temp	265 to 275	°C
Mold Temperature	55.0 to 95.0	°C

NOTE

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

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