

Starflam R10002E

Polyamide 66/6 Copolymer
Eurostar Engineering Plastics

Message:

R10002E is Unfilled, Halogen Free and Red Phosphorous Free, Flame Retardant, Polyamide 66/ Polyamide 6 Injection Molding Resin (also known as R1000Z220EM)

General Information			
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	1.17	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.80 to 1.5	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ISO 527-2/1
Tensile Stress (Yield)	75.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	%	ISO 527-2
Flexural Modulus ²	3500	MPa	ISO 178
Flexural Stress	105	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	60	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	200	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	80.0	°C	ISO 75-2/Af
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
0.400 mm, Nat	V-0		
0.800 mm, All Colors	V-0		
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	260 to 270	°C	

Middle Temperature	265 to 280	°C
Front Temperature	270 to 280	°C
Processing (Melt) Temp	265 to 280	°C
Mold Temperature	60.0 to 90.0	°C

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

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