

Staramide P1000IX3

Polyamide 6
Eurostar Engineering Plastics

Message:

Staramide P1000IX3 is an Impact Modified Polyamide 6 Injection Molding Resin (also known as P1000HI020 or Star X 2020)

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.4	%	Internal Method
Water Absorption (23°C, 24 hr)	2.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2000	MPa	ISO 527-2/1
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	4.1	%	ISO 527-2/50
Flexural Modulus ¹	1600	MPa	ISO 178
Flexural Stress	61.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	36	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	136	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	48.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.4E-4	cm/cm/°C	
Transverse : 23 to 60°C	1.6E-4	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	220 to 230	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	240 to 250	°C	
Processing (Melt) Temp	240 to 250	°C	
Mold Temperature	60.0 to 90.0	°C	

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

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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