

# Staramide R1000K

Polyamide 66  
Eurostar Engineering Plastics

Message:  
Staramide R1000K is an Unreinforced Radiation Crosslinkable Polyamide 66 Injection Molding Resin

| General Information                                                          |                           |                   |                 |
|------------------------------------------------------------------------------|---------------------------|-------------------|-----------------|
| Features                                                                     | Irradiation Crosslinkable |                   |                 |
| RoHS Compliance                                                              | RoHS Compliant            |                   |                 |
| Processing Method                                                            | Injection Molding         |                   |                 |
| Physical                                                                     | Nominal Value             | Unit              | Test Method     |
| Density                                                                      | 1.15                      | g/cm <sup>3</sup> | ISO 1183        |
| Molding Shrinkage - Flow (4.00 mm)                                           | 1.4 to 1.6                | %                 | Internal Method |
| Mechanical                                                                   | Nominal Value             | Unit              | Test Method     |
| Tensile Stress (Break)                                                       | 80.0                      | MPa               | ISO 527-2/5     |
| Tensile Strain (Break)                                                       | 3.0                       | %                 | ISO 527-2/5     |
| Flexural Modulus <sup>1</sup>                                                | 2500                      | MPa               | ISO 178         |
| Flexural Stress                                                              | 100                       | MPa               | ISO 178         |
| Impact                                                                       | Nominal Value             | Unit              | Test Method     |
| Notched Izod Impact Strength <sup>2</sup> (23°C)                             | 4.0                       | kJ/m <sup>2</sup> | ISO 180/1A      |
| Unnotched Izod Impact Strength <sup>3</sup> (23°C)                           | 25                        | kJ/m <sup>2</sup> | ISO 180/1U      |
| Thermal                                                                      | Nominal Value             | Unit              | Test Method     |
| Heat Deflection Temperature <sup>4</sup> (1.8 MPa, Unannealed, 64.0 mm Span) | 56.0                      | °C                | ISO 75-2/Af     |
| Injection                                                                    | Nominal Value             | Unit              |                 |
| Suggested Max Moisture                                                       | 0.20                      | %                 |                 |
| Rear Temperature                                                             | 265 to 275                | °C                |                 |
| Middle Temperature                                                           | 265 to 275                | °C                |                 |
| Front Temperature                                                            | 265 to 275                | °C                |                 |
| Processing (Melt) Temp                                                       | 265 to 275                | °C                |                 |
| Mold Temperature                                                             | 60.0 to 80.0              | °C                |                 |
| NOTE                                                                         |                           |                   |                 |
| 1.                                                                           | 2.0 mm/min                |                   |                 |
| 2.                                                                           | 80*10*4                   |                   |                 |
| 3.                                                                           | 80*10*4                   |                   |                 |
| 4.                                                                           | 80*10*4                   |                   |                 |

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