

Starflam AFR450B1

Polyamide 66
Eurostar Engineering Plastics

Message:

Starflam AFR450B1 is a Flame Retardant, Glass Fiber Reinforced Polyamide 66 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Flame Retardant		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.56	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.30	%	Internal Method
Water Absorption (Saturation, 23°C)	4.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9100	MPa	ISO 527-2/1
Tensile Stress (Break)	150	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ²	8900	MPa	ISO 178
Flexural Stress	215	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³			ISO 180/1A
-20°C	6.0	kJ/m ²	
23°C	7.0	kJ/m ²	
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, 100 mm Span	256	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	240	°C	ISO 75-2/Ae
Vicat Softening Temperature	255	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 60°C	3.0E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	375	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm, Tested by E2P)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
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	270 to 280	°C
Front Temperature	270 to 285	°C
Processing (Melt) Temp	270 to 285	°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.	120*10*4

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