

# Staramide RF005S

Polyamide 66

Eurostar Engineering Plastics

## Message:

Staramide RF005S is a 25 % Glass Fiber Reinforced Polyamide 66 Injection Molding Resin

| General Information                                                         |                                  |                   |                 |
|-----------------------------------------------------------------------------|----------------------------------|-------------------|-----------------|
| Filler / Reinforcement                                                      | Glass Fiber,25% Filler by Weight |                   |                 |
| RoHS Compliance                                                             | RoHS Compliant                   |                   |                 |
| Processing Method                                                           | Injection Molding                |                   |                 |
| Physical                                                                    | Nominal Value                    | Unit              | Test Method     |
| Density                                                                     | 1.31                             | g/cm <sup>3</sup> | ISO 1183        |
| Molding Shrinkage - Flow <sup>1</sup>                                       | 0.25 to 0.45                     | %                 | Internal Method |
| Water Absorption (Saturation, 23°C)                                         | 6.0                              | %                 | ISO 62          |
| Mechanical                                                                  | Nominal Value                    | Unit              | Test Method     |
| Tensile Modulus                                                             | 7100                             | MPa               | ISO 527-2/1     |
| Tensile Stress (Break)                                                      | 150                              | MPa               | ISO 527-2/5     |
| Tensile Strain (Break)                                                      | 3.5                              | %                 | ISO 527-2/5     |
| Flexural Modulus <sup>2</sup>                                               | 7200                             | MPa               | ISO 178         |
| Flexural Stress                                                             | 190                              | MPa               | ISO 178         |
| Impact                                                                      | Nominal Value                    | Unit              | Test Method     |
| Charpy Unnotched Impact Strength <sup>3</sup><br>(23°C)                     | 45                               | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Notched Izod Impact Strength <sup>4</sup>                                   |                                  |                   | ISO 180/1A      |
| -40°C                                                                       | 9.0                              | kJ/m <sup>2</sup> |                 |
| -20°C                                                                       | 9.0                              | kJ/m <sup>2</sup> |                 |
| 23°C                                                                        | 9.0                              | kJ/m <sup>2</sup> |                 |
| Thermal                                                                     | Nominal Value                    | Unit              | Test Method     |
| Heat Deflection Temperature <sup>5</sup> (1.8 MPa, Unannealed, 100 mm Span) | 250                              | °C                | ISO 75-2/Ae     |
| Thermal Conductivity                                                        | 0.33                             | W/m/K             | ASTM E1530      |
| 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 280                       | °C                |                 |
| Middle Temperature                                                          | 270 to 280                       | °C                |                 |
| Front Temperature                                                           | 270 to 290                       | °C                |                 |
| Processing (Melt) Temp                                                      | 270 to 290                       | °C                |                 |
| Mold Temperature                                                            | 60.0 to 90.0                     | °C                |                 |
| NOTE                                                                        |                                  |                   |                 |

|    |                 |
|----|-----------------|
| 1. | Tensile Bar     |
| 2. | 2.0 mm/min      |
| 3. | 80*10*4 sp=62mm |
| 4. | 80*10*4         |
| 5. | 120*10*4        |

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