

Starflam PX06091

Polyamide 6
Eurostar Engineering Plastics

Message:
Starflam PX06091 is an Unfilled, Halogen Free and Red Phosphorous Free, Flame Retardant Polyamide 6 Injection Molding Resin

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	1.16	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.0	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ISO 527-2/1
Tensile Stress (Yield)	78.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	3.7	%	
Break	5.6	%	
Flexural Modulus ¹	3100	MPa	ISO 178
Flexural Stress	105	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ²			
0.45 MPa, Unannealed, 64.0 mm Span	190	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	75.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	7.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	8.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	V-0		UL 94
Glow Wire Flammability Index (0.750 mm)	960	°C	IEC 60695-2-12
Oxygen Index	32	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	240 to 250	°C
Middle Temperature	250 to 260	°C
Front Temperature	250 to 270	°C
Processing (Melt) Temp	250 to 270	°C
Mold Temperature	50.0 to 90.0	°C

NOTE

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

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