

Staramide PF004EUC

Polyamide 6
Eurostar Engineering Plastics

Message:
Staramide PF004EUC is a 20 % Glass Fiber Reinforced Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.34	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6300	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	117	MPa	
Break	110	MPa	
Tensile Strain (Yield)	3.0	%	ISO 527-2/5
Flexural Modulus ¹	4800	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	163	MPa	
-- ⁴	147	MPa	
Flexural Strain at Break ⁵	7.6	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁶ (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁷ (23°C)	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸ (1.8 MPa, Unannealed, 64.0 mm Span)	177	°C	ISO 75-2/Af
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (1.60 mm)	650	°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	230 to 240	°C	
Middle Temperature	240 to 250	°C	

Front Temperature	240 to 270	°C
Processing (Melt) Temp	240 to 270	°C
Mold Temperature	60.0 to 80.0	°C

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	Yield	
4.	Break	
5.	2.0 mm/min	
6.	80*10*4	
7.	80*10*4	
8.	80*10*4	

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