

Star L PA6 D51

Polyamide 6
Eurostar Engineering Plastics

Message:
Star L PA6 D51 is a 15% PTFE Lubricated, Unreinforced, Polyamide 6 Injection Molding Resin

General Information			
Additive	PTFE Lubricant (15%)		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.8 to 2.2	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	62.0	MPa	ISO 527-2
Tensile Strain (Break)	12	%	ISO 527-2
Flexural Modulus	2200	MPa	ISO 178
Flexural Stress	84.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ¹ (23°C)	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ² (23°C)	50	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (0.45 MPa, Unannealed, 100 mm Span)	110	°C	ISO 75-2/Be
Melting Temperature (DSC)	225	°C	ISO 3146
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	235 to 245	°C	
Front Temperature	240 to 260	°C	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			
1.	80*10*4		
2.	80*10*4		
3.	120*10*4		

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