

Staramide ACF6

Polyamide 66
Eurostar Engineering Plastics

Message:
Staramide ACF6 is a 30 % Carbon Fiber Reinforced Polyamide 66 injection Molding Resin

General Information			
Filler / Reinforcement	Carbon Fiber,30% 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 ¹	0.040 to 0.080	%	Internal Method
Water Absorption (Saturation, 23°C)	4.5	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	22000	MPa	ISO 527-2/1
Tensile Stress (Break)	250	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ²	19500	MPa	ISO 178
Flexural Stress	360	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength ³ (23°C)	70	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength ⁴			ISO 180/1A
-40°C	6.0	kJ/m ²	
-20°C	7.0	kJ/m ²	
23°C	8.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 100 mm Span	260	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	257	°C	ISO 75-2/Ae
Vicat Softening Temperature	255	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.4E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁶	> 4.3E+3	ohms	IEC 60093
Volume Resistivity	> 4.3E+3	ohms · cm	IEC 60093

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Tested by E2P)	HB		UL 94
Oxygen Index	27	%	ISO 4589-2
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	70.0 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		
6.	ROA		

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