

Starflam PK0022E

Polyamide 6
Eurostar Engineering Plastics

Message:

PK0022E is a Halogen Free Red Phosphorous Free Flame Retardant, Mineral Filled, Polyamide 6 Injection Molding (also known as PM362OZ22 or PA6 10E6 U9 Z22)

General Information			
Filler / Reinforcement	Mineral		
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	1.24	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	1.2 to 1.4	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	69.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.1	%	ISO 527-2/5
Flexural Modulus ²	3400	MPa	ISO 178
Flexural Stress	102	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed, 64.0 mm Span)	71.0	°C	ISO 75-2/Af
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Tested by E2P)	V-2		UL 94
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
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.	Tensile Bar	
2.	2.0 mm/min	
3.	80*10*4	
4.	80*10*4	
5.	80*10*4	

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