

Staramide RFB24

Polyamide 66

Eurostar Engineering Plastics

Message:

Staramide RFB24 is Glass Bead and Glass Fiber Reinforced Polyamide 66 Injection Molding Resin (also known as Staramide 66 2010VK Z3)

General Information			
Filler / Reinforcement	Glass Bead\Glass Fiber		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.40	%	Internal Method
Water Absorption (23°C, 24 hr)	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7800	MPa	ISO 527-2/1
Tensile Stress (Break)	147	MPa	ISO 527-2/5
Tensile Strain (Break)	3.4	%	ISO 527-2/5
Flexural Modulus ¹	6500	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	215	MPa	
-- ⁴	213	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵ (23°C)	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁶ (23°C)	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed, 64.0 mm Span	257	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	238	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	3.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.0E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	265 to 280	°C	
Middle Temperature	270 to 285	°C	
Front Temperature	270 to 290	°C	
Processing (Melt) Temp	270 to 285	°C	

Mold Temperature	60.0 to 100	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	Yield	
4.	Break	
5.	80*10*4	
6.	80*10*4	
7.	80*10*4	

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