

Starflam AFR460B

Polyamide 66

Eurostar Engineering Plastics

Message:

Starflam AFR460B is a Flame Retardant Glass Fiber Reinforced Polyamide 66 Injection Molding Resin

General Information			
UL YellowCard	E340012-100755277		
Filler / Reinforcement	Glass Fiber		
Features	Flame Retardant		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.30	%	Internal Method
Water Absorption (Saturation, 23°C)	4.0	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1
Tensile Stress (Break)	165	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ²	9300	MPa	ISO 178
Flexural Stress	190	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength ³ (23°C)	60	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength ⁴			ISO 180/1A
-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	262	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	248	°C	ISO 75-2/Ae
Vicat Softening Temperature	258	°C	ISO 306/B120
Ball Pressure Test ⁶ (125°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.3E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.2E-5	cm/cm/°C	
RTI Elec	65.0	°C	UL 746

RTI Imp	65.0	°C	UL 746
RTI Str	65.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Oxygen Index	31	%	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 270	°C	
Middle Temperature	270 to 280	°C	
Front Temperature	270 to 285	°C	
Processing (Melt) Temp	270 to 285	°C	
Mold Temperature	60.0 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.	125°C ±2°C		

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