

Staramide ACF4

Polyamide 66

Eurostar Engineering Plastics

Message:

Staramide ACF4 is a 20 % Carbon Fiber Reinforced Polyamide 66 injection Molding Resin

General Information			
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
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	0.10 to 0.15	%	Internal Method
Water Absorption (Saturation, 23°C)	5.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15000	MPa	ISO 527-2/1
Tensile Stress (Break)	190	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ²	12500	MPa	ISO 178
Flexural Stress	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³			ISO 180/1A
-40°C	5.0	kJ/m ²	
-20°C	6.0	kJ/m ²	
23°C	8.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 100 mm Span	255	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	250	°C	ISO 75-2/Ae
Vicat Softening Temperature	255	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.7E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.1E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁵	> 1.8E+5	ohms	IEC 60093
Volume Resistivity	> 1.8E+5	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
4.	120*10*4
5.	ROA

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