

Star L PA6 30V D61

Polyamide 6
Eurostar Engineering Plastics

Message:

Star L PA6 30V D61 is a PTFE / Silicone Oil Lubricated, Glass Fiber Reinforced, Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	PTFE + Silicone Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.20 to 0.40	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	155	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	7800	MPa	ISO 178
Flexural Stress	195	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ¹ (23°C)	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ² (23°C)	65	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 64.0 mm Span)	195	°C	ISO 75-2/Af
Melting Temperature (DSC)	225	°C	ISO 3146
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.	80*10*4		
2.	80*10*4		
3.	80*10*4		

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