

Starflam RF0077E

Polyamide 66
Eurostar Engineering Plastics

Message:

Starflam RF0077E is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Fiber Reinforced, Polyamide 66 Injection Molding Resin (also known as RF1007Z270)

General Information			
Filler / Reinforcement	Glass Fiber		
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	1.47	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow	0.70 to 1.1	%	
Flow : 4.00 mm	0.10 to 0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11500	MPa	ISO 527-2/1
Tensile Stress (Break)	155	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus ¹	10400	MPa	ISO 178
Flexural Stress	216	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	55	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	245	°C	ISO 75-2/Af
Ball Pressure Test ⁵ (240°C)	Pass		IEC 60695-10-2
RTI Elec	140	°C	UL 746
RTI Imp	110	°C	UL 746
RTI Str	140	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112
High Amp Arc Ignition (HAI)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 0		UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-0		UL 94
Glow Wire Flammability Index (0.800 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	775	°C	
1.50 mm	775	°C	
3.00 mm	825	°C	

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	265 to 275	°C
Middle Temperature	265 to 275	°C
Front Temperature	270 to 280	°C
Processing (Melt) Temp	270 to 280	°C
Mold Temperature	60.0 to 100	°C

NOTE	
1.	2.0 mm/min
2.	80*10*4
3.	80*10*4
4.	80*10*4
5.	Approximate maximum

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