

Staramide PF006

Polyamide 6
Eurostar Engineering Plastics

Message:
Staramide PF006 is a 30 % Glass Fiber Reinforced Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Molding Shrinkage ¹			Internal Method
Across Flow	0.80 to 1.1	%	
Flow	0.20 to 0.40	%	
Water Absorption			ISO 62
Saturation, 23°C	6.5	%	
Equilibrium, 23°C, 50% RH	1.8	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	111		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1
Tensile Stress (Break)	160	MPa	ISO 527-2/5
Tensile Strain (Break)	3.7	%	ISO 527-2/5
Flexural Modulus ²	8000	MPa	ISO 178
Flexural Stress	230	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179/1eA
-30°C	9.0	kJ/m ²	
23°C	11	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179/1eU
-30°C	75	kJ/m ²	
23°C	90	kJ/m ²	
Notched Izod Impact Strength ⁵			ISO 180/1A
-40°C	9.0	kJ/m ²	
-30°C	9.0	kJ/m ²	
-20°C	10	kJ/m ²	
23°C	11	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			

0.45 MPa, Unannealed, 100 mm Span	220	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	205	°C	ISO 75-2/Ae
Vicat Softening Temperature	215	°C	ISO 306/B50, ISO 306/B120
Ball Pressure Test ⁷ (125°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	8.5E-5	cm/cm/°C	
Thermal Conductivity	0.33	W/m/K	ISO 8302
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁸	> 1.0E+16	ohms	IEC 60093
Volume Resistivity	> 1.0E+16	ohms·cm	IEC 60093
Electric Strength (3.20 mm, in Oil)	20	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	3.60		
60 Hz	3.60		
1 MHz	3.40		
Dissipation Factor			IEC 60250
50 Hz	6.1E-3		
60 Hz	6.1E-3		
1 MHz	0.016		
Comparative Tracking Index			IEC 60112
--	500	V	
Solution B	375	V	
Flammability	Nominal Value	Unit	Test Method
Burning Rate			FMVSS 302
2.00 mm	6.0	mm/min	
3.00 mm	2.0	mm/min	
Flame Rating (0.750 mm, Tested by E2P)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Oxygen Index	25	%	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	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		

3.	80*10*4 sp=62mm
4.	80*10*4 sp=62mm
5.	80*10*4
6.	120*10*4
7.	125°C ±2°C
8.	ROA

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