

Staramide PF003IX1

Polyamide 6

Eurostar Engineering Plastics

Message:

Staramide PF003IX1 is an Impact Modified Glass Fiber Reinforced Polyamide 6 Injection Molding Resin (also know as PF1003HI005)

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Impact Modifier		
Features	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.10 to 0.30	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4900	MPa	ISO 527-2/1
Tensile Stress (Yield)	105	MPa	ISO 527-2/5
Tensile Strain (Yield)	> 3.0	%	ISO 527-2/5
Flexural Modulus ²	4200	MPa	ISO 178
Flexural Stress	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³			ISO 180/1A
-30°C	7.0	kJ/m ²	
23°C	15	kJ/m ²	
Unnotched Izod Impact Strength ⁴			ISO 180/1U
-30°C	65	kJ/m ²	
23°C	65	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed, 64.0 mm Span)	176	°C	ISO 75-2/Af
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 260	°C	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	60.0 to 80.0	°C	

NOTE	
1.	Tensile Bar
2.	2.0 mm/min
3.	80*10*4
4.	80*10*4
5.	80*10*4

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