

Starflam PX06012

Polyamide 6
Eurostar Engineering Plastics

Message:
Starflam PX06012 is an Unfilled, Halogen Free and Red Phosphorous Free, Flame Retardant, Polyamide 6 Injection Molding Resin

General Information			
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	1.15	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.3	%	Internal Method
Water Absorption (23°C, 24 hr)	2.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	69.0	MPa	
Break	57.0	MPa	
Tensile Strain (Yield)	3.5	%	ISO 527-2/5
Flexural Modulus ¹	2500	MPa	ISO 178
Flexural Stress	97.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	120	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	164	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	58.0	°C	ISO 75-2/Af
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm, Tested by E2P)	V-2		UL 94
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. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 |

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