

Starflam P10003

Polyamide 6

Eurostar Engineering Plastics

Message:

Starflam P10003 is a Mineral Flame Retardant, Halogen Free, Red Phosphorous Free, Polyamide 6 Injection Molding Resin

General Information			
Additive	Flame Retardant 2		
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	1.50	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.0	%	Internal Method
Water Absorption (23°C, 24 hr)	0.90	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6700	MPa	ISO 527-2/1
Tensile Stress (Yield)	71.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.7	%	ISO 527-2/5
Flexural Modulus ¹	6200	MPa	ISO 178
Flexural Stress	122	MPa	ISO 178
Flexural Strain at Break ²	4.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	179	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	94.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	6.4E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.7E-5	cm/cm/°C	
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	245 to 255	°C
Middle Temperature	250 to 260	°C
Front Temperature	250 to 260	°C
Processing (Melt) Temp	255 to 265	°C
Mold Temperature	55.0 to 95.0	°C

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |
| 3. | 80*10*4 |
| 4. | 80*10*4 |
| 5. | 80*10*4 |

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