

Starflam PK0052E

Polyamide 6
Eurostar Engineering Plastics

Message:

PK0052E is a Halogen Free and Red Phosphorous, Free Flame Retardant, Mineral Filled, Polyamide 6 Injection Molding (also known as PM3650Z222 or PA6 25E6 U9 Z22)

General Information			
Filler / Reinforcement	Mineral		
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	1.37	g/cm ³	ISO 1183
Molding Shrinkage - Flow (24 hr)	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6200	MPa	ISO 527-2/1
Tensile Stress (Break)	70.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	5100	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ¹ (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ² (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³			
0.45 MPa, Unannealed, 64.0 mm Span	185	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	88.0	°C	ISO 75-2/Af
Ball Pressure Test ⁴ (125°C)	Pass		IEC 60695-10-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index	450	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Tested by E2P)	V-2		UL 94
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
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. | 80*10*4 |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 125°C ±2°C |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

