

Starflam RF0052E

Polyamide 66/6 Copolymer
Eurostar Engineering Plastics

Message:

Starflam RF0052E is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Reinforced, Polyamide 66 / Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber		
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 ¹	0.40 to 0.60	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8100	MPa	ISO 527-2/1
Tensile Stress (Break)	120	MPa	ISO 527-2/5
Tensile Strain (Break)	2.7	%	ISO 527-2/5
Flexural Modulus ²	6700	MPa	ISO 178
Flexural Stress	185	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	251	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	215	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	3.6E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.1E-4	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	265 to 275	°C
Middle Temperature	265 to 275	°C
Front Temperature	270 to 280	°C
Processing (Melt) Temp	270 to 280	°C
Mold Temperature	60.0 to 100	°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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