

Starflam PFB139E

Polyamide 6
Eurostar Engineering Plastics

Message:
Starflam PFB139E is a Flame Retardant Glass Bead and Glass Fiber Reinforced Polyamide 6 Injection Molding Resin (also known as PFB1013Z590)

General Information			
Filler / Reinforcement	Glass Bead\Glass Fiber		
Features	Flame Retardant		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.52	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.30	%	Internal Method
Water Absorption (23°C, 24 hr)	1.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6800	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	121	MPa	
Break	121	MPa	
Tensile Strain			ISO 527-2/5
Yield	2.7	%	
Break	2.7	%	
Flexural Modulus ¹	5900	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	169	MPa	
-- ⁴	170	MPa	
Flexural Strain at Break ⁵	3.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁶ (23°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁷ (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸			
0.45 MPa, Unannealed, 64.0 mm Span	203	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	175	°C	ISO 75-2/ Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.2E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.7E-5	cm/cm/°C	
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		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.	2.0 mm/min
3.	Break
4.	Yield
5.	2.0 mm/min
6.	80*10*4
7.	80*10*4
8.	80*10*4

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