

Staramide PF00AS

Polyamide 6
Eurostar Engineering Plastics

Message:
Staramide PF00AS is a 50 % Glass Fiber Reinforced Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.15 to 0.35	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15000	MPa	ISO 527-2/1
Tensile Stress (Break)	220	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
Flexural Modulus ¹	15000	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ³ (23°C)	85	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength ⁴ (23°C)	19	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁵ (23°C)	90	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 100 mm Span)	205	°C	ISO 75-2/Ae
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	250 to 260	°C	
Middle Temperature	260 to 280	°C	
Front Temperature	260 to 280	°C	
Processing (Melt) Temp	260 to 280	°C	
Mold Temperature	50.0 to 90.0	°C	
NOTE			
1.	2.0 mm/min		
2.	80*10*4 sp=62mm		
3.	80*10*4 sp=62mm		

4.	80*10*4
5.	80*10*4
6.	120*10*4

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