

Staramide RF004EU

Polyamide 66/6 Copolymer
Eurostar Engineering Plastics

Message:

Staramide* RF004EU is a 20 % Glass Fiber Reinforced Polyamide 66/6 Injection Molding Resin (also known as Staramide* 66C 20V S4)

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.10 to 0.40	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7000	MPa	ISO 527-2/1
Tensile Strength (Break)	130	MPa	ASTM D638
Tensile Strain (Break)	> 3.0	%	ISO 527-2
Flexural Modulus	6000	MPa	ISO 178
Flexural Strength	195	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ² (23°C)	55	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength ³ (23°C)	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	48	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	221	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	255 to 275	°C	
Middle Temperature	265 to 275	°C	
Front Temperature	265 to 275	°C	
Processing (Melt) Temp	265 to 275	°C	
NOTE			
1.	80*10*4 sp=62mm		
2.	80*10*4 sp=62mm		
3.	80*10*4		
4.	80*10*4		

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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

