

# Staramide R1000

Polyamide 66  
Eurostar Engineering Plastics

Message:  
Staramide R1000 is an Unreinforced Polyamide 66 Injection Molding Resin

| General Information                                  |                   |                   |                 |
|------------------------------------------------------|-------------------|-------------------|-----------------|
| RoHS Compliance                                      | RoHS Compliant    |                   |                 |
| Processing Method                                    | Injection Molding |                   |                 |
| Physical                                             | Nominal Value     | Unit              | Test Method     |
| Density                                              | 1.14              | g/cm <sup>3</sup> | ISO 1183        |
| Molding Shrinkage - Flow <sup>1</sup>                | 1.6 to 2.0        | %                 | Internal Method |
| Water Absorption                                     |                   |                   | ISO 62          |
| Saturation, 23°C                                     | 8.5               | %                 |                 |
| Equilibrium, 23°C, 50% RH                            | 2.0               | %                 |                 |
| Mechanical                                           | Nominal Value     | Unit              | Test Method     |
| Tensile Modulus                                      | 3000              | MPa               | ISO 527-2/1     |
| Tensile Stress (Yield)                               | 85.0              | MPa               | ISO 527-2/50    |
| Tensile Strain (Break)                               | > 20              | %                 | ISO 527-2/50    |
| Flexural Modulus <sup>2</sup>                        | 2800              | MPa               | ISO 178         |
| Flexural Stress                                      | 105               | MPa               | ISO 178         |
| Impact                                               | Nominal Value     | Unit              | Test Method     |
| Charpy Notched Impact Strength <sup>3</sup> (23°C)   | 5.0               | kJ/m <sup>2</sup> | ISO 179/1eA     |
| Charpy Unnotched Impact Strength <sup>4</sup> (23°C) | > 100             | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Notched Izod Impact Strength <sup>5</sup>            |                   |                   | ISO 180/1A      |
| -20°C                                                | 4.0               | kJ/m <sup>2</sup> |                 |
| 23°C                                                 | 5.0               | kJ/m <sup>2</sup> |                 |
| Thermal                                              | Nominal Value     | Unit              | Test Method     |
| Heat Deflection Temperature <sup>6</sup>             |                   |                   |                 |
| 0.45 MPa, Unannealed, 100 mm Span                    | 210               | °C                | ISO 75-2/Be     |
| 1.8 MPa, Unannealed, 100 mm Span                     | 90.0              | °C                | ISO 75-2/Ae     |
| Vicat Softening Temperature                          |                   |                   |                 |
| --                                                   | 243               | °C                | ISO 306/B50     |
| --                                                   | 240               | °C                | ISO 306/B120    |
| Ball Pressure Test <sup>7</sup> (125°C)              | Pass              |                   | IEC 60695-10-2  |
| 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       | 260 to 270   | °C |
| Middle Temperature     | 270 to 280   | °C |
| Front Temperature      | 270 to 290   | °C |
| Processing (Melt) Temp | 270 to 290   | °C |
| Mold Temperature       | 60.0 to 90.0 | °C |

| NOTE |                 |  |
|------|-----------------|--|
| 1.   | Tensile Bar     |  |
| 2.   | 2.0 mm/min      |  |
| 3.   | 80*10*4 sp=62mm |  |
| 4.   | 80*10*4 sp=62mm |  |
| 5.   | 80*10*4         |  |
| 6.   | 120*10*4        |  |
| 7.   | 125°C ±2°C      |  |

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