

Star L PA66 D91

Polyamide 66
Eurostar Engineering Plastics

Message:
Star L PA66 D91 is a PTFE lubricated, Aramid Fiber Reinforced , Polyamide 66 Injection Molding Resin

General Information			
Filler / Reinforcement	Aramid Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.2 to 1.8	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	88.0	MPa	ISO 527-2
Tensile Strain (Break)	6.0	%	ISO 527-2
Flexural Modulus	3500	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ¹ (23°C)	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ² (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³			
0.45 MPa, Unannealed, 100 mm Span	241	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	125	°C	ISO 75-2/Ae
Melting Temperature (DSC)	265	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	265 to 275	°C	
Middle Temperature	270 to 280	°C	
Front Temperature	270 to 280	°C	
Processing (Melt) Temp	270 to 280	°C	
Mold Temperature	60.0 to 100	°C	
NOTE			
1.	80*10*4		
2.	80*10*4		

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