

Staramide A24G6K

Polyamide 66

Eurostar Engineering Plastics

Message:

Staramide A24G6K is an Easy Flow, Heat and Hydrolytically Stabilized, 30 % Glass Fiber Reinforced Polyamide 66 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
	Hydrolysis Resistant		
Features	Good Flow		
	Heat Stabilized		
	Hydrolytically Stable		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.40	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	4.5	%	
Equilibrium, 23°C, 50% RH	1.2	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	114		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9400	MPa	ISO 527-2/1
Tensile Stress (Break)	170	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ²	9000	MPa	ISO 178
Flexural Stress	260	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179/1eA
-30°C	7.0	kJ/m ²	
23°C	8.0	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179/1eU
-30°C	55	kJ/m ²	
23°C	75	kJ/m ²	
Notched Izod Impact Strength ⁵			ISO 180/1A
-40°C	6.0	kJ/m ²	

-20°C	7.0	kJ/m ²	
23°C	8.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, Unannealed, 100 mm Span	260	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	250	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	260	°C	ISO 306/B50
--	258	°C	ISO 306/B120
Ball Pressure Test ⁷ (125°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.5E-5	cm/cm/°C	
Thermal Conductivity	0.33	W/m/K	ISO 8302
RTI Elec	110	°C	UL 746
RTI Imp	95.0	°C	UL 746
RTI Str	120	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁸	> 1.0E+16	ohms	IEC 60093
Volume Resistivity	> 1.0E+16	ohms·cm	IEC 60093
Electric Strength (3.20 mm, in Oil)	20	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	3.40		
60 Hz	3.40		
1 MHz	3.20		
Dissipation Factor			IEC 60250
50 Hz	7.0E-3		
60 Hz	7.0E-3		
1 MHz	0.016		
Comparative Tracking Index			IEC 60112
--	500	V	
Solution B	400	V	
Flammability	Nominal Value	Unit	Test Method
Burning Rate			FMVSS 302
2.00 mm	6.0	mm/min	
3.00 mm	2.0	mm/min	
Flame Rating			UL 94
0.750 mm	HB		
3.00 mm	HB		
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Oxygen Index	26	%	ISO 4589-2
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 280	°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

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|----|-----------------|
| 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 |
| 8. | ROA |

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