Starflam RFB247EX

Polyamide 66/6 Copolymer

Eurostar Engineering Plastics

Message:

RFB247EX is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Bead / Glass Fiber Reinforced, Polyamide 66/ Polyamide 6 Injection Molding Resin.

General Information			
Filler / Reinforcement	Glass Bead\Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant Halogen Free Low (to None) Phosphorus Content		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.44	g/cm³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.40 to 0.60	%	Internal Method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield)	114	MPa	ISO 527-2
Tensile Strain (Break)	2.6	%	ISO 527-2
Flexural Modulus	7600	MPa	ISO 178
Flexural Stress	161	MPa	ISO 178
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature [1] (1.8 MPa, Unannealed, 100 mm Span)	210	°C	ISO 75-2/Ae
Flammability	**Nominal Value**		**Test Method**
Flame Rating (1.60 mm, Tested by E2P)	V-0		UL 94
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 285	°C	
Front Temperature	265 to 280	°C	
Processing (Melt) Temp	265 to 280	°C	
Mold Temperature	70.0 to 90.0	°C	
NOTE			
1.	120*10*4		

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