

Staramide PF006IX1

Polyamide 6
Eurostar Engineering Plastics

Message:

Staramide PF006IX1 is an Impact Modified, Glass Fiber Reinforced, Polyamide 6 Injection Molding Resin (also known as Star X R2005-30V)

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Impact Modifier		
Features	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.50	%	Internal Method
Ash Content (650°C)	30	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8000	MPa	ISO 527-2/1
Tensile Stress (Yield)	160	MPa	ISO 527-2/5
Tensile Strain (Yield)	2.0 to 3.0	%	ISO 527-2/5
Flexural Modulus ²	7000	MPa	ISO 178
Flexural Stress	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³			ISO 180/1A
-30°C	10	kJ/m ²	
23°C	20	kJ/m ²	
Unnotched Izod Impact Strength ⁴			ISO 180/1U
-30°C	75	kJ/m ²	
23°C	75	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed, 64.0 mm Span)	190	°C	ISO 75-2/Af
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	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	240 to 260	°C	
Processing (Melt) Temp	240 to 260	°C	

Mold Temperature	60.0 to 80.0	°C
NOTE		
1.	Tensile Bar	
2.	2.0 mm/min	
3.	80*10*4	
4.	80*10*4	
5.	80*10*4	

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