

Staramide 12 85E11

Polyamide 12
Eurostar Engineering Plastics

Message:
Staramide 12 85E11 is a High Density Polyamide 12 Injection Molding Resin

General Information			
Features	High density		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	4.20	g/cm ³	ISO 1183
shrinkage-Flow (4.00 mm)	0.80 - 1.0	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	26.0	MPa	ISO 527-2
Tensile Strain (Break)	1.0	%	ISO 527-2
Flexural Modulus ¹	4600	MPa	ISO 178
Flexural Stress	40.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	5.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	7.0	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ² (1.8 MPa, Unannealed, 64.0 mm Span)	92.0	°C	ISO 75-2/Af
Melting Temperature (DSC)	180	°C	ISO 3146
Injection	Nominal Value	Unit	
Rear Temperature	200 - 240	°C	
Middle Temperature	230 - 260	°C	
Front Temperature	240 - 260	°C	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	60 - 90	°C	
Injection instructions			
Zone 4 Temperature: 240 to 260°C			
NOTE			
1.	2.0 mm/min		
2.	80x10x4 mm		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

