

Staramide RF004XXC

Polyamide 66

Eurostar Engineering Plastics

Message:

Staramide* RF004XXC is a 20 % Glass Fiber Reinforced Polyamide 66 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.50	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	120	MPa	ISO 527-2/5
Tensile Strain (Break)	2.2	%	ISO 527-2/5
Flexural Modulus	6000	MPa	ISO 178
Flexural Stress	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 100 mm Span)	230	°C	ISO 75-2/Ae
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			
1.	Tensile Bar		
2.	80*10*4		
3.	80*10*4		
4.	120*10*4		

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