

Staramide P1000IX2

Polyamide 6
Eurostar Engineering Plastics

Message:

Staramide P1000IX2 is an Impact Modified Polyamide 6 Injection Molding Resin (also known as P1000HI010 or Star X 2010)

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.4 to 1.6	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			ISO 527-2
Yield	55.0	MPa	
Break	40.0	MPa	
Tensile Strain (Break)	80	%	ISO 527-2
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress	77.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ²			ISO 179/1eA
-30°C	13	kJ/m ²	
23°C	17	kJ/m ²	
Charpy Unnotched Impact Strength ³			ISO 179/1eU
-30°C	85	kJ/m ²	
23°C	> 100	kJ/m ²	
Notched Izod Impact Strength ⁴			ISO 180/1A
-30°C	13	kJ/m ²	
23°C	15	kJ/m ²	
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-30°C	75	kJ/m ²	
23°C	> 100	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 100 mm Span)	64.0	°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	220 to 230	°C
Middle Temperature	230 to 240	°C
Front Temperature	240 to 250	°C
Processing (Melt) Temp	240 to 250	°C
Mold Temperature	60.0 to 90.0	°C

NOTE		
1.	2.0 mm/min	
2.	80*10*4 sp=62mm	
3.	80*10*4 sp=62mm	
4.	80*10*4	
5.	80*10*4	
6.	120*10*4	

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