

Starflam RF0067K

Polyamide 66
Eurostar Engineering Plastics

Message:

Starflam RF0067K is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Fiber Reinforced, Polyamide 66 Injection Molding, CrossLinkable under Beta or Gamma Radiation. Data provided for material not crosslinled (0 kGy)

General Information			
UL YellowCard	E340012-102711182		
Filler / Reinforcement	Glass fiber reinforced material		
Additive	Flame retardancy		
Features	Radiation crosslinkable		
	Phosphorus content, low (to none)		
	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
shrinkage-Flow	0.20 - 0.40	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	110	MPa	ISO 527-2/5
Tensile Strain (Break)	1.8	%	ISO 527-2/5
Flexural Modulus ¹	8200	MPa	ISO 178
Flexural Stress	141	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ² (1.8 MPa, Unannealed, 64.0 mm Span)	197	°C	ISO 75-2/Af
Flammability	Nominal Value	Unit	Test Method
Flame Rating ³ (0.8 mm)	V-0		UL 94
Glow Wire Flammability Index ⁴ (1.5 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	260 - 280	°C	
Middle Temperature	265 - 285	°C	
Front Temperature	280 - 290	°C	

Processing (Melt) Temp	270 - 290	°C
Mold Temperature	60 - 90	°C
Back Pressure	> 1.00	MPa
Screw Speed	80 - 120	rpm

NOTE

- | | |
|----|--------------------|
| 1. | 2.0 mm/min |
| 2. | 80x10x4 mm |
| 3. | Before Irradiation |
| 4. | Before Irradiation |

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Recommended distributors for this material

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



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