

Starflam PX06011

Polyamide 6
Eurostar Engineering Plastics

Message:

Starflam PX06011 is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced PA6 Injection Molding Resin (also known as Starflam PF1005Z222)

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
	Low (to None) Phosphorus Content		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.40 to 0.60	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	93.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus ¹	6300	MPa	ISO 178
Flexural Stress	136	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	3.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	196	°C	ISO 75-2/Af
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, Tested by E2P)	V-2		UL 94
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	240 to 250	°C	
Middle Temperature	250 to 260	°C	
Front Temperature	250 to 270	°C	
Processing (Melt) Temp	250 to 270	°C	

Mold Temperature	50.0 to 90.0	°C
NOTE		
1.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	80*10*4	

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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

