

Staramide PF005

Polyamide 6
Eurostar Engineering Plastics

Message:
Staramide PF005 is a 25 % Glass Fiber Reinforced Polyamide 6 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.20 to 0.40	%	Internal Method
Water Absorption (Saturation, 23°C)	6.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	145	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ²	7500	MPa	ISO 178
Flexural Stress	190	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	50	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 100 mm Span	215	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	205	°C	ISO 75-2/Ae
Ball Pressure Test ⁶ (125°C)	Pass		IEC 60695-10-2
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	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4		

4.	80*10*4
5.	120*10*4
6.	125 ±2°C

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