

Star X 1615 33V S4

Polyamide 66
Eurostar Engineering Plastics

Message:

Star X 1615 33V S4 is an Impact Modified, Glass Fiber Reinforced , UV stabilized Polyamide 66 Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Impact Modifier		
	UV Stabilizer		
Features	Good UV Resistance		
	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.10 to 0.40	%	Internal Method
Ash Content (650°C)	33	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7300	MPa	ISO 527-2/1
Tensile Stress (Yield)	115	MPa	ISO 527-2
Tensile Strain (Break)	4.0 to 6.0	%	ISO 527-2
Flexural Modulus	6100	MPa	ISO 178
Flexural Stress	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	30	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ² (23°C)	90	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength ³			ISO 180/1A
-30°C	18	kJ/m ²	
23°C	30	kJ/m ²	
Unnotched Izod Impact Strength ⁴			ISO 180/1U
-30°C	85	kJ/m ²	
23°C	90	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed, 100 mm Span)	230	°C	ISO 75-2/Ae
Melting Temperature (DSC)	260	°C	ISO 3146
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.	80*10*4 sp=62mm
2.	80*10*4 sp=62mm
3.	80*10*4
4.	80*10*4
5.	120*10*4

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