

DESCRIPTION Starflam PF0047E is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Fiber Reinforced, Polyamide 6 Injection Molding Resin

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
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PHYSICAL

Density	g/cm ³	ISO 1183	1.36
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	0.2 - 0.4

MECHANICAL

Flexural Modulus	MPa	ISO 178	7000
Flexural Stress	MPa	ISO 178	190
Tensile Modulus, 1 mm/min	MPa	ISO 527	7500
Tensile Strain, break	%	ISO 527	3.5
Tensile Stress, break	MPa	ISO 527	120

IMPACT

Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	8
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	45

THERMAL

HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	195
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FLAME CHARACTERISTICS

DIN 5510 (grey color GY4D542)		DIN 5510	S4 - SR2 - ST2
UL E2P measurement, 94V1 Flame Class Rating	mm	UL 94 by E2P	1.6

Source RJF, last update 01-07-2010

(1) Typical values for natural color unless specified otherwise. Do not constitute a specification. Significant variations are possible for colors

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PARAMETER	SETTING	UNIT
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.2	%
Mold Temperature	50 - 90	°C
Rear - Zone 1 Temperature	240 - 250	°C
Middle - Zone 2 Temperature	250 - 260	°C
Front - Zone 3 Temperature	250 - 270	°C
Melt Temperature	250 - 270	°C

PROCESSING PARAMETERS: see above typical molding conditions.

DRYING: is not essential when material is delivered in sealed bags with moisture content below 0.2%.

BARRELS, SCREWS, MOULDS: use wear resisting steel or alloy such as bimetallic cylinders, nitrided screws.

USE OF REGRIND: the properties of the component should be checked in order to ascertain the maximum acceptable level of regrind.

SAFETY: please refer to Material Safety Datasheet

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