

Staramide® P1000IX1

Technical DataSheet | Supplied by Eurostar Engineering Plastics

Staramide® P1000IX1 is an impact modified PA 6 grade. Processed by injection molding. It is also known as P1000HI006 or Star X 2006.

Product Type	PA (Polyamide, Nylon) > PA 6 (Nylon 6)
Physical Form	Pellets
Product Status	COMMERCIAL
Applications/ Recommended for	Injection molding - thermoplastics
Key Features	Impact modified

Staramide® P1000IX1 Properties

Physical	Value & Unit	Test Condition	Test Method
Specific Gravity	1.11 g/cm ³	23°C	ISO 1183

Thermal	Value & Unit	Test Condition	Test Method
Heat Deflection Temperature (HDT)	50 °C	1.8 MPa Flatw 80*10*4 sp=64mm	ISO 75/Af
Heat Deflection Temperature (HDT)	145 °C	0.45 MPa Flatw 80*10*4 sp=64mm	ISO 75/Bf

Mechanical	Value & Unit	Test Condition	Test Method
Impact Strength, Notched Izod	9 kJ/m ²	23°C	ISO 180

Tensile Strain	3.8 %	at Yield, 23°C	ISO 527-2
Tensile Modulus	2500 MPa	23°C	ISO 527-2
Impact Strength, Unnotched Izod	96 kJ/m ²	23°C	ISO 180
Tensile Strength	60 MPa	at Yield, 23°C	ISO 527-2
Impact Strength, Unnotched Izod	NB kJ/m ²	23°C	ISO 180

Staramide® P1000IX1 Processing Guidelines

Injection Molding	Value & Unit	Test Condition	Test Method
Drying Temperature	75 - 85 °C		
Rear- Zone 1 Temperature	220 - 230 °C		
Drying Time	4 - 6 hr		
Middle- Zone 2 Temperature	230 - 240 °C		
Suggested Max Moisture	0.2 %		
Front- Zone 3 Temperature	240 - 250 °C		
Mold Temperature	60 - 90 °C		
Mold Shrinkage, flow (4mm thickness)	2.3 %		
Processing (Melt) Temp	240 - 250 °C		

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