

DESCRIPTION Starflam PF0023E is a Mineral Flame Retardant, Halogen Free Red, Phosphorous Free, 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	1.67
Mold Shrinkage, flow, 24 hrs (5)	%	ISO 294	0.3 - 0.5

MECHANICAL

Flexural Modulus	MPa	ISO 178	11000
Flexural Stress	MPa	ISO 178	150
Tensile Modulus, 1 mm/min	MPa	ISO 527	11600
Tensile Stress, break	MPa	ISO 527	95

IMPACT

Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	3
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	25

THERMAL

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

UL E2P measurement, 94V-0 Flame Class Rating	mm	UL 94 by E2P	1.6
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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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EUROSTAR Engineering Plastics, ZI - Rue de la Ferme Saint Ladre, BP2, F/95471 Fosses Cedex FRANCE,

Tel: + 33 1 34 47 47 00, Fax: + 33 1 34 47 47 18 - www.eurostar-ep.com

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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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