

Starflam

Starflam PK0022E

DESCRIPTION PK0022E is a Halogen Free Red Phosphorous Free Flame Retardant, Mineral Filled, Polyamide 6 Injection Molding (also known as PM3620Z22 or PA6 10E6 U9 Z22)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm ³	ISO 1183	1.24
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	1.2 - 1.4
MECHANICAL			
Flexural Modulus, 2 mm/min	MPa	ISO 178	3400
Flexural Stress, break, 2 mm/min	MPa	ISO 178	102
Tensile Strain, break, 5 mm/min	%	ISO 527	3.1
Tensile Stress, break, 5 mm/min	MPa	ISO 527	69
IMPACT			
Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	4
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	71
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 960°C, passes at	mm	IEC 60695-2-12	1.6
UL E2P measurement, 94V-2 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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