

Starflam

Starflam PW0042E

DESCRIPTION Starflam PW0042E is a Halogen Free and Red Phosphorous Free, Flame Retardant, Mineral Reinforced Polyamide 6 Injection Molding Resin

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm ³	ISO 1183	1.33
Mold Shrinkage, flow, 24 hrs (5)	%	ISO 294	0.5 - 0.8
MECHANICAL			
Flexural Modulus	MPa	ISO 178	6000
Flexural Stress	MPa	ISO 178	130
Tensile Modulus, 1 mm/min	MPa	ISO 527	6400
Tensile Strain, break	%	ISO 527	3
Tensile Stress, break	MPa	ISO 527	90
IMPACT			
Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	5
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	100
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 960°C, passes at	mm	IEC 60695-2-12	0.8
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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