Starflam

Starflam PZ0042E

DESCRIPTION PZ0042E is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced Polyamide 6 Molding Resin (known as PF1004Z222 or PA620GFU9Z22)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm^3	ISO 1183	1.33
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	0.7 - 0.9
MECHANICAL			
Flexural Modulus, 2 mm/min	MPa	ISO 178	6150
Flexural Stress, break, 2 mm/min	MPa	ISO 178	160
Tensile Modulus, 1 mm/min	MPa	ISO 527	6200
Tensile Strain, break, 5 mm/min	%	ISO 527	3.2
Tensile Stress, break, 5 mm/min	MPa	ISO 527	95
IMPACT			
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	kJ/m^2	ISO 179/1eU	50
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	kJ/m^2	ISO 179/1eA	7
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/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Ae	185
Relative Temp Index, Elec	°C	UL 746B	125
Vicat Softening Temp, Rate B/50	°C	ISO 306	209
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 960°C, passes at	mm	IEC 60695-2-12	2
UL Recognized, 94V-2 Flame Class Rating	mm	UL 94	0.75
ELECTRICAL			
Comparative Tracking Index	V	IEC 60112	500

Source RJF, last update 01-07-2010

(1) Typical values for natural color unless specified otherwise. Do no 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 injection 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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