

Starflam

Starflam PZ0052E

DESCRIPTION PZ0052E is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced Polyamide 6 Molding Resin (known as PF1005Z222 or PA625GFU22)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm ³	ISO 1183	1.38
Density	g/cm ³	ASTM D 792	1.39
Moisture Absorption, 50% RH, 24 hrs	%	ASTM D 570	1.05
Mold Shrinkage, flow, 24 hrs (5)	%	ISO 294	0.4 - 0.6
MECHANICAL			
Flexural Modulus	MPa	ASTM D 790	7100
Flexural Modulus	MPa	ISO 178	5200
Flexural Stress	MPa	ISO 178	120
Flexural Stress	MPa	ASTM D 790	144
Tensile Modulus, 1 mm/min	MPa	ISO 527	6100
Tensile Modulus, 50 mm/min	MPa	ASTM D 638	7440
Tensile Strain, break	%	ISO 527	2.5
Tensile Strain, break	%	ASTM D 638	2.3
Tensile Stress, break	MPa	ASTM D 638	103
Tensile Stress, break	MPa	ISO 527	82
IMPACT			
Instrumented Impact Energy @ peak, 23°C	J	ASTM D 3763	8
Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	3
Izod Impact, notched, 23°C	J/m	ASTM D 256	53
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	25
Izod Impact, unnotched, 23°C	J/m	ASTM D 4812	469
Multiaxial Impact	J	ISO 6603	8
THERMAL			
CTE, -40°C to 40°C, flow	1/°C	ASTM E 831	3.24E-05
HDT, 0.45 MPa, 3.2 mm, unannealed	°C	ASTM D 648	215
HDT, 1.82 MPa, 3.2mm, unannealed	°C	ASTM D 648	204
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	137

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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PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
FLAME CHARACTERISTICS			
Oxygen Index (LOI)	%	ISO 4589	>20
UL E2P measurement, 94V-2 Flame Class Rating	mm	UL 94 by E2P	0.75

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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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