

# Starflam

## Starflam PX06011

**DESCRIPTION** Starflam PX06011 is a Halogen Free and Red Phosphorous Free, Flame Retardant, Glass Reinforced PA6 Injection Molding Resin (also known as Starflam PF1005Z222)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
<b>PHYSICAL</b>			
Density	g/cm <sup>3</sup>	ISO 1183	1.43
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	0.4 - 0.6
<b>MECHANICAL</b>			
Flexural Modulus, 2 mm/min	MPa	ISO 178	6300
Flexural Stress, yield, 2 mm/min	MPa	ISO 178	136
Tensile Strain, break, 5 mm/min	%	ISO 527	2.1
Tensile Stress, yield, 5 mm/min	MPa	ISO 527	93
<b>IMPACT</b>			
Izod Impact, notched 80*10*4 +23°C	kJ/m <sup>2</sup>	ISO 180/1A	3
Izod Impact, unnotched 80*10*4 +23°C	kJ/m <sup>2</sup>	ISO 180/1U	30
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	196
<b>FLAME CHARACTERISTICS</b>			
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, print date 26-09-2011

(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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