

DESCRIPTION Starflam RF0067K is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Fiber Reinforced, Polyamide 66 Injection Molding, CrossLinkable under Beta or Gamma Radiation. Data provided for material not crosslinked (0 kGy)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
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PHYSICAL

Density	g/cm ³	ISO 1183	1.45
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	0.2 - 0.4

MECHANICAL

Flexural Modulus, 2 mm/min	MPa	ISO 178	8200
Flexural Stress, break, 2 mm/min	MPa	ISO 178	141
Tensile Strain, break, 5 mm/min	%	ISO 527	1.8
Tensile Stress, break, 5 mm/min	MPa	ISO 527	110

IMPACT

Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	7
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	30

THERMAL

HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	197
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FLAME CHARACTERISTICS

UL Listed, 94V0, 0 kGy Before Irradiation	mm	UL 94	0.8
UL Listed, 94V0, 0-100kGy Irradiation, BLACK ONLY	mm	UL 94	0.4
UL Listed, 94V1, 100 kGy max. After Irradiation	mm	UL 94	0.8

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
Maximum Moisture Content	0.2	%
Mold Temperature	60 - 90	°C
Rear - Zone 1 Temperature	260 - 280	°C
Middle - Zone 2 Temperature	265 - 285	°C
Front - Zone 3 Temperature	280 - 290	°C
Melt Temperature	270 - 290	°C
Screw Speed	80 -120	rpm
Back Pressure	>1	MPa
Drying Temperature	80	°C
Drying Time	4	hrs

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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