STARFLAM

RF0052E

DESCRIPTION Starflam RF0052E is a Halogen Free and Red Phosphorous Free Flame Retardant, Glass Reinforced, Polyamide 66 / Polyamide 6 Injection Molding Resin

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm^3	ISO 1183	1.37
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	0.4 - 0.6
MECHANICAL			
Flexural Modulus, 2 mm/min	MPa	ISO 178	6700
Flexural Stress, yield, 2 mm/min	MPa	ISO 178	185
Tensile Modulus, 1 mm/min	MPa	ISO 527	8100
Tensile Strain, break, 5 mm/min	%	ISO 527	2.7
Tensile Stress, break, 5 mm/min	MPa	ISO 527	120
IMPACT			
Izod Impact, notched 80*10*4 +23°C	kJ/m^2	ISO 180/1A	6
Izod Impact, unnotched 80*10*4 +23°C	kJ/m^2	ISO 180/1U	40
THERMAL			
CTE, 23°C to 60°C, flow	1/°C	ISO 11359-2	3.60E-05
CTE, 23°C to 60°C, xflow	1/°C	ISO 11359-2	1.09E-04
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	215
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Bf	251
FLAME CHARACTERISTICS			
UL E2P measurement, 94V-2 Flame Class Rating	mm	UL 94 by E2P	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
Drying Temperature	80	˚C
Drying Time	4	hrs
Maximum Moisture Content	0.2	%
Mold Temperature	60 - 100	˚C
Rear – Zone 1 Temperature	265 - 275	˚C
Middle – Zone 2 Temperature	265 - 275	˚C
Front – Zone 3 Temperature	270 - 280	˚C
Melt Temperature	270 - 280	˚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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