Starflam® RX12414
polyamide 66

Starflam RX12414 is a radiation cross-linkable resin, unfilled, flame retardant PA66 for injection molded applications. The material is halogen free and red phosphorus free.

General		
Material Status	• Commercial: Active	
Availability	• Europe	
Additive	• Flame Retardant	• Heat Stabilizer
Features	• Flame Retardant	• Halogen Free
Uses	• Electrical/Electronic Applications	• Industrial Applications
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm³	ISO 1183
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Stress (Yield, 23°C)	50.0	--	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	11	--	%	ISO 527-2
Flexural Modulus (23°C)	2300	--	MPa	ISO 178
Flexural Strength (23°C)	77.0	--	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Unnotched Izod Impact Strength (23°C)	30	--	kJ/m²	ISO 180
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/A
1.8 MPa, Unannealed	50.0	--	°C	
RTI Elec				UL 746B
0.8 mm	130	--	°C	
1.6 mm	130	--	°C	
3.0 mm	130	--	°C	
RTI Imp				UL 746B
0.8 mm	65.0	--	°C	
1.6 mm	65.0	--	°C	
3.0 mm	65.0	--	°C	
RTI Str				UL 746B
0.8 mm	65.0	--	°C	
1.6 mm	65.0	--	°C	
3.0 mm	65.0	--	°C	

Electrical	Dry	Conditioned	Unit	Test Method
High Amp Arc Ignition (HAI)				UL 746
0.8 mm	PLC 0	--		
1.6 mm	PLC 0	--		
3.0 mm	PLC 0	--		
Hot-wire Ignition (HWI)				UL 746
0.8 mm	PLC 1	--		
1.6 mm	PLC 1	--		
3.0 mm	PLC 0	--		

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.8 mm	V-1	--		
1.6 mm	V-1	--		
3.0 mm	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.8 mm	960	--	°C	
1.6 mm	960	--	°C	
3.0 mm	960	--	°C	

Injection	Dry	Unit
Drying Temperature	80	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	265 to 275	°C
Middle Temperature	275 to 285	°C
Front Temperature	275 to 285	°C
Processing (Melt) Temp	270 to 290	°C
Mold Temperature	70 to 90	°C

Notes

Typical properties: these are not to be construed as specifications.

[1] Typical properties: these are not to be construed as specifications.

North America
+1 888 927 2363

Europe
+32 10 608 600

Asia
+86 21 2315 0888