

Starflam® AFR450B1

polyamide 66



Starflam AFR450B1 is a flame retardant, 25% glass fiber reinforced PA66 for injection molded applications.

| General | | | | |
|---------------------------------------|-------------------------|-------------------|-----------------|----------------|
| Additive | • Flame Retarding Agent | • Heat Stabilizer | • Release agent | |
| Features | • Flame Retardant | • Halogenated | | |
| Appearance | • Natural Color | | | |
| Forms | • Pellets | | | |
| Processing Method | • Injection Molding | | | |
| Physical | dry | cond. | Unit | Test Standard |
| Density | 1.56 | - | g/cm³ | ISO 1183 |
| Water Absorption, Saturation, 23°C | 4.5 | | % | ISO 62 |
| Mechanical | dry | cond. | Unit | Test Standard |
| Tensile Modulus (23°C) | 9100 | - | MPa | ISO 527-2 |
| Tensile Stress (Break, 23°C) | 150 | - | MPa | ISO 527-2 |
| Tensile Strain (Break, 23°C) | 2 | - | % | ISO 527-2 |
| Flexural Modulus (23°C) | 8900 | - | MPa | ISO 178 |
| Flexural Strength (23°C) | 215 | - | MPa | ISO 178 |
| Impact | dry | cond. | Unit | Test Standard |
| Notched Izod Impact Strength | | | | ISO 180/1A |
| +23°C | 7 | - | kJ/m² | |
| -30°C | 6 | - | kJ/m² | |
| Unnotched Izod Impact Strength, +23°C | 60 | - | kJ/m² | ISO 180/1U |
| Thermal | dry | cond. | Unit | Test Standard |
| CLTE | | | | ISO 11359-2 |
| Flow : 23 to 55°C, 2.00 mm | 30 | * | E-6/K | |
| Transverse : 23 to 55°C, 2.00 mm | 90 | * | E-6/K | |
| Electrical | Value | | Unit | Test Standard |
| Comparative Tracking Index (3.00 mm) | 375 | | V | IEC 60112 |
| Flammability | Value | | Unit | Test Standard |
| Glow Wire Flammability Index | | | | IEC 60695-2-12 |
| 2.00 mm | 960 | | °C | |

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| Injection | Value | Unit |
|-------------------------------|-----------|------|
| Drying Temperature | 75 - 85 | °C |
| Drying Time | 4 - 6 | h |
| Suggested Max Moisture | 0.2 | % |
| Rear Temperature | 260 - 270 | °C |
| Middle Temperature | 270 - 280 | °C |
| Front Temperature | 270 - 285 | °C |
| Processing (Melt) Temperature | 270 - 285 | °C |
| Mold Temperature | 60 - 90 | °C |



North America
+1 888 927 2363

Europe
+32 10 608 600

Asia
+86 21 2315 0888

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