

Starflam® PX05004

polyamide 66



Starflam PX05004 is a 20% glass filled, flame retardant PA66 + PA6 for injection molded applications. The material is halogen free and red phosphorus free.

General				
Additive	• Flame Retarding Agent	• Heat Stabilizer	• Release agent	
Features	• Flame Retardant			
Agency Rating	• ISO, 1043 PA66+PA6 GF20 FR(30)			
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			
Physical	dry	cond.	Unit	Test Standard
Density	1.34	-	g/cm ³	ISO 1183
Mechanical	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	5700	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	84	-	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.2	-	%	ISO 527-2
Flexural Modulus (23°C)	5300	-	MPa	ISO 178
Flexural Strength (23°C)	147	-	MPa	ISO 178
Impact	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	4	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	30	-	kJ/m ²	ISO 180/1U
Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature, 1.80 MPa, Unannealed	185	-	°C	ISO 75-2/A
Flammability	Value		Unit	Test Standard
Flammability				UL 94
1.60 mm	V-2			
Glow Wire Flammability Index				IEC 60695-2-12
0.800 mm	960		°C	

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Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%
Rear Temperature	255 - 265	°C
Middle Temperature	260 - 270	°C
Front Temperature	260 - 270	°C
Processing (Melt) Temperature	265 - 275	°C
Mold Temperature	55 - 95	°C



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