

LNP* Starflam* Compound PK0069

Asia Pacific: COMMERCIAL

Also known as: LNP* Starflam* Compound PM-3660 Z880

Product reorder name: PK0069

LNP STARFLAM* PM-3660 Z880 is a compound based on Nylon 6 resin containing Flame Retardant, Mineral. Added features of this material include: Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, break	60	MPa	ISO 527
Tensile Strain, break	2 - 3	%	ISO 527
Tensile Modulus, 1 mm/min	7300	MPa	ISO 527
Flexural Stress	95	MPa	ISO 178
Flexural Modulus	5700	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	195	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	120	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 24 hrs	0.4 - 0.6	%	ISO 294
Density	1.6	g/cm ³	ISO 1183
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.5	mm	UL 94 by GE

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	255 - 265	°C
Front - Zone 3 Temperature	250 - 260	°C
Middle - Zone 2 Temperature	250 - 260	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	55 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm