Starflam® PX06009

Ascend Performance Materials Operations LLC - *Polyamide 6*

General Information

Product Description

Starflam PX06009 is a 20% glass filled, flame retardant PA6 for injection molded applications. The material is halogen free and red phosphorus free.

General			
Material Status	• Commercial: Active		
Availability	• Europe	• North America	
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• Flame Retardant	• Heat Stabilizer	• Mold Release
Features	• Flame Retardant	• Heat Stabilized	
Agency Ratings	• ISO 1043 PA6 GF20 FR(30)		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		
Resin ID	• PA6-GF20 FR		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm³	ISO 1183
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	899000	psi	ISO 527-1
Tensile Stress (Break, 73°F)	13800	psi	ISO 527-2
Tensile Strain (Break, 73°F)	3.2	%	ISO 527-2
Flexural Modulus (73°F)	899000	psi	ISO 178
Flexural Stress (73°F)	23200	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength (73°F)	2.4	ft·lb/in²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	21	ft·lb/in²	ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
RTI Elec			UL 746B
0.030 in	257	°F	
0.031 in	257	°F	
0.04 in	257	°F	
0.06 in	257	°F	
0.12 in	257	°F	
RTI Imp			UL 746B
0.030 in	257	°F	
0.031 in	257	°F	
0.04 in	257	°F	
0.06 in	257	°F	
0.12 in	257	°F	
RTI Str			UL 746B
0.030 in	266	°F	
0.031 in	266	°F	
0.04 in	266	°F	
0.06 in	266	°F	
0.12 in	284	°F	
Electrical	**Nominal Value**	**Unit**	**Test Method**

Comparative Tracking Index (0.118 in)	600	V	IEC 60112
High Amp Arc Ignition (HAI)			UL 746A
0.030 in	PLC 0		
0.03 in	PLC 0		
0.04 in	PLC 0		
0.06 in	PLC 0		
0.12 in	PLC 0		
Hot-wire Ignition (HWI)			UL 746A
0.030 in	PLC 3		
0.03 in	PLC 0		
0.04 in	PLC 0		
0.06 in	PLC 0		
0.12 in	PLC 0		

Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.030 in	V-2		
0.031 in	V-2		
0.04 in	V-2		
0.06 in	V-2		
0.12 in	V-2		
Glow Wire Flammability Index (0.04 in)	1760	°F	IEC 60695-2-12
Glow Wire Ignition Temperature (0.04 in)	1340	°F	IEC 60695-2-13

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	176	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	464 to 482	°F
Middle Temperature	482 to 500	°F
Front Temperature	482 to 518	°F
Processing (Melt) Temp	482 to 518	°F
Mold Temperature	122 to 194	°F

Notes

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