

**Starflam® PK0069**

Ascend Performance Materials Operations LLC - Polyamide 6

## General Information

**Product Description**

Starflam PK0069 is a mineral filled, flame retardant, PA6, for injection molded applications.

**General**

Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Mineral, 30% Filler by Weight
Additive	• Flame Retardant • Heat Stabilizer • Mold Release
Features	• Flame Retardant • Halogenated • Heat Stabilized
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID	• PA6-MF30 FR

 Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm <sup>3</sup>	ISO 1183
Water Absorption (24 hr, 73°F)	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	899000	psi	ISO 527-1
Tensile Stress (Break, 73°F)	9140	psi	ISO 527-2
Tensile Strain (Break, 73°F)	1.5	%	ISO 527-2
Flexural Modulus (73°F)	1.07E+6	psi	ISO 178
Flexural Stress (73°F)	14600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	2.4	ft-lb/in <sup>2</sup>	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	7.1	ft-lb/in <sup>2</sup>	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	379	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	266	°F	ISO 75-2/A
RTI Elec (0.06 in)	149	°F	UL 746B
RTI Imp (0.06 in)	149	°F	UL 746B
RTI Str (0.06 in)	149	°F	UL 746B
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

## 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

<sup>1</sup> Typical properties: these are not to be construed as specifications.
