Starflam® PX06012

Ascend Performance Materials Operations LLC - *Polyamide 6*

General Information

Product Description

Starflam PX06012 is an unfilled, 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
Additive	• Flame Retardant	• Mold Release
Features	• Bromine Free	• Flame Retardant
Agency Ratings	• ISO 1043 PA6 FR(30)	
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	
Resin ID	• PA6 FR	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm³	ISO 1183
Water Absorption (24 hr, 73°F)	2.3	%	ISO 62
Outdoor Suitability	f2		UL 746C
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	464000	psi	ISO 527-1
Tensile Stress (Yield, 73°F)	10000	psi	ISO 527-2
Tensile Stress (Break, 73°F)	8270	psi	ISO 527-2
Tensile Strain (Yield, 73°F)	3.5	%	ISO 527-2
Flexural Modulus (73°F)	363000	psi	ISO 178
Flexural Stress (73°F)	14100	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength (73°F)	1.9	ft·lb/in²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	55	ft·lb/in²	ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	327	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	136	°F	ISO 75-2/A
RTI Elec			UL 746B
0.030 in	248	°F	
0.06 in	248	°F	
0.12 in	248	°F	
RTI Imp			UL 746B
0.030 in	149	°F	
0.06 in	167	°F	
0.12 in	167	°F	
RTI Str			UL 746B
0.030 in	185	°F	
0.06 in	185	°F	
0.12 in	185	°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		
0.06 in	PLC 0		
0.12 in	PLC 0		
Hot-wire Ignition (HWI) (0.030 in)	PLC 0		UL 746A

Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.016 in	V-0		
0.030 in	V-0		
0.06 in	V-0		
0.12 in	V-0		
Glow Wire Flammability Index (0.030 in)	1760	°F	IEC 60695-2-12
Glow Wire Ignition Temperature (0.030 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.