Starflam® PX06010

Ascend Performance Materials Operations LLC - *Polyamide 6*

General Information

Product Description

Starflam PX06010 is a 25% 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, 25% Filler by Weight		
Additive	• Flame Retardant	• Heat Stabilizer	• Mold Release
Features	• Flame Retardant	• Heat Stabilized	
Agency Ratings	• ISO 1043 PA6 GF25 FR(30)		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		
Resin ID	• PA6-GF25 FR		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm³	ISO 1183
Water Absorption (24 hr, 73°F)	1.9	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	914000	psi	ISO 527-1
Tensile Stress (Yield, 73°F)	12200	psi	ISO 527-2
Tensile Stress (Break, 73°F)	11700	psi	ISO 527-2
Tensile Strain (Yield, 73°F)	2.3	%	ISO 527-2
Flexural Modulus (73°F)	798000	psi	ISO 178
Flexural Stress (73°F)	19900	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)	17	ft·lb/in²	ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	403	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	316	°F	ISO 75-2/A
RTI Elec			UL 746B
0.030 in	257	°F	
0.06 in	257	°F	
0.12 in	257	°F	
RTI Imp			UL 746B
0.030 in	257	°F	
0.06 in	257	°F	
0.12 in	257	°F	
RTI Str			UL 746B
0.030 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)	400 to 599	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)		UL 746A
0.030 in	PLC 2	
0.06 in	PLC 2	
0.12 in	PLC 2	

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.030 in	V-2		
0.06 in	V-2		
0.12 in	V-2		

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.