

Starflam® PX05004

Ascend Performance Materials Operations LLC - Polyamide 66

General Information

Product Description

Starflam PX05004 is a 20% glass filled, flame retardant PA66 + PA6 for injection molded applications. The material is halogen free and red phosphorus free.

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • 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 PA66+PA6 GF20 FR(30)
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID	• PA66-GF20 FR

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	827000	psi	ISO 527-1
Tensile Stress (Yield, 73°F)	12200	psi	ISO 527-2
Tensile Strain (Break, 73°F)	2.2	%	ISO 527-2
Flexural Modulus (73°F)	769000	psi	ISO 178
Flexural Stress (73°F)	21300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	1.9	ft·lb/in ²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	14	ft·lb/in ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	365	°F	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-2		UL 94
Glow Wire Flammability Index (0.031 in)	1760	°F	IEC 60695-2-12

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	491 to 509	°F
Middle Temperature	500 to 518	°F
Front Temperature	500 to 518	°F
Processing (Melt) Temp	509 to 527	°F
Mold Temperature	131 to 203	°F

