

Starflam® PK0069

polyamide 6



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

General

Regional Availability	• North America	• Europe	
Additive	• Flame Retarding Agent	• Heat Stabilizer	• Release agent
Features	• Flame Retardant	• Halogenated	
Uses	• Mineral Reinforced		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.66	-	g/cm ³	ISO 1183
Water Absorption, 23°C, 24 hr	0.8	*	%	ISO 62

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	6200	-	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	63	-	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	1.5	-	%	ISO 527-2
Flexural Modulus (23°C)	7400	-	MPa	ISO 178
Flexural Strength (23°C)	101	-	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	5	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	15	-	kJ/m ²	ISO 180/1U

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	130	-	°C	
0.45 MPa, Unannealed	193	-	°C	
RTI Elec				UL 746
1.50 mm	65		°C	
RTI Imp				UL 746
1.50mm	65		°C	
RTI Str				UL 746
1.50 mm	65		°C	

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Flammability	Value	Test Standard
Flammability 1.50 mm	V-0	UL 94

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%
Rear Temperature	240 - 250	°C
Middle Temperature	250 - 260	°C
Front Temperature	250 - 270	°C
Processing (Melt) Temperature	250 - 270	°C
Mold Temperature	50 - 90	°C

