

Starflam® PX06004

polyamide 6

Starflam PX06004 is an unfilled, flame retardant PA6 for injection molded applications. The material is halogen free and red phosphorus free.

General

Regional Availability	• North America	• Europe	
Additive	• Flame Retarding Agent	• Heat Stabilizer	• Release agent
Features	• Flame Retardant		
Agency Rating	• ISO, 1043 PA6 FR(30)		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.16	-	g/cm ³	ISO 1183
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	2.2	*	%	
Water Absorption, Saturation, 23°C	9		%	ISO 62
Outdoor Suitability	f2		-	UL 746C

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	3400	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	78	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.7	-	%	ISO 527-2
Tensile Strain (Break, 23°C)	5.6	-	%	ISO 527-2
Flexural Modulus (23°C)	3100	-	MPa	ISO 178
Flexural Strength (23°C)	105	-	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	5	-	kJ/m ²	
-30°C	3	-	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	100	-	kJ/m ²	
-30°C	100	-	kJ/m ²	
Notched Izod Impact Strength, +23°C	5	-	kJ/m ²	ISO 180/1A

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Thermal	Value	Unit	Test Standard
RTI Elec			UL 746
0.750 mm	120	°C	
1.50 mm	120	°C	
3.00 mm	120	°C	
RTI Imp			UL 746
0.750 mm	65	°C	
1.50mm	75	°C	
3.00 mm	75	°C	
RTI Str			UL 746
0.750 mm	85	°C	
1.50 mm	85	°C	
3.00 mm	85	°C	
Electrical	Value	Unit	Test Standard
Comparative Tracking Index (3.00 mm)	600	V	IEC 60112
High Amp Arc Ignition (HAI)			UL 746
0.750 mm	PLC 0	-	
1.50 mm	PLC 0	-	
3.00 mm	PLC 0	-	
Hot-wire Ignition (HWI)			UL 746
0.750 mm	PLC 4	-	
Flammability	Value	Unit	Test Standard
Flammability			UL 94
0.400 mm	V-0	-	
0.750 mm	V-0	-	
1.50 mm	V-0	-	
3.00 mm	V-0	-	
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	725	°C	
Injection	Value	Unit	
Drying Temperature	80	°C	
Drying Time	4	h	
Suggested Max Moisture	0.2	%	
Rear Temperature	240 - 250	°C	

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Middle Temperature	250 - 260	°C
Front Temperature	250 - 270	°C
Processing (Melt) Temperature	250 - 270	°C
Mold Temperature	50 - 90	°C

