

Starflam® PX06009

polyamide 6

Starflam PX06009 is a 20% glass filled, 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 GF20 FR(30)		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.33	-	g/cm ³	ISO 1183

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	6200	-	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	95	-	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3.2	-	%	ISO 527-2
Flexural Modulus (23°C)	6200	-	MPa	ISO 178
Flexural Strength (23°C)	160	-	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	45	-	kJ/m ²	ISO 180/1U

Thermal

	Value	Unit	Test Standard
RTI Elec			UL 746
0.750 mm	125	°C	
0.800 mm	125	°C	
1.00 mm	125	°C	
1.50 mm	125	°C	
3.00 mm	125	°C	
RTI Imp			UL 746
0.750 mm	125	°C	
0.800 mm	125	°C	
1.00 mm	125	°C	

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1.50mm	125	°C	
3.00 mm	125	°C	
RTI Str			UL 746
0.750 mm	130	°C	
0.800 mm	130	°C	
1.00 mm	130	°C	
1.50 mm	130	°C	
3.00 mm	140	°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	-	
0.800 mm	PLC 0	-	
1.00 mm	PLC 0	-	
1.50 mm	PLC 0	-	
3.00 mm	PLC 0	-	
Hot-wire Ignition (HWI)			UL 746
0.750 mm	PLC 3	-	
0.800 mm	PLC 0	-	
1.00 mm	PLC 0	-	
1.50 mm	PLC 0	-	
3.00 mm	PLC 0	-	

Flammability	Value	Unit	Test Standard
Flammability			UL 94
0.750 mm	V-2	-	
0.800 mm	V-2	-	
1.00 mm	V-2	-	
1.50 mm	V-2	-	
3.00 mm	V-2	-	
Glow Wire Flammability Index			IEC 60695-2-12
1.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	725	°C	

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%

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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

