

Starflam® PX06010

polyamide 6



Starflam PX06010 is a 25% 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 GF25 FR(30)		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.37	-	g/cm ³	ISO 1183
Water Absorption, 23°C, 24 hr	1.9	*	%	ISO 62

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	6300	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	84	-	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	81	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	2.3	-	%	ISO 527-2
Flexural Modulus (23°C)	5500	-	MPa	ISO 178
Flexural Strength (23°C)	137	-	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	35	-	kJ/m ²	ISO 180/1U

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	158	-	°C	
0.45 MPa, Unannealed	206	-	°C	
RTI Elec				UL 746
0.750 mm	125		°C	
1.50 mm	125		°C	
3.00 mm	125		°C	
RTI Imp				UL 746

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0.750 mm	125	°C	
1.50mm	125	°C	
3.00 mm	125	°C	
RTI Str			UL 746
0.750 mm	130	°C	
1.50 mm	130	°C	
3.00 mm	140	°C	

Electrical	Value	Unit	Test Standard
Comparative Tracking Index (3.00 mm)	400 - 599	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 2	-	
1.50 mm	PLC 2	-	
3.00 mm	PLC 2	-	

Flammability	Value	Test Standard
Flammability		UL 94
0.750 mm	V-2	
1.50 mm	V-2	
3.00 mm	V-2	

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