

Starflam® PX06011

polyamide 6



Starflam PX06011 (formerly PF1005Z222) is a 25% glass filled, flame retardant PA6 for injection molded applications. The material is halogen free flame retardant 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	1.43	-	g/cm ³	ISO 1183

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Stress (Yield, 23°C)	93	-	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.1	-	%	ISO 527-2
Flexural Modulus (23°C)	6300	-	MPa	ISO 178
Flexural Strength (23°C)	136	-	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	3	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	30	-	kJ/m ²	ISO 180/1U

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature, 1.80 MPa, Unannealed	196	-	°C	ISO 75-2/A

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

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Mold Temperature

50 - 90

°C

