

Starflam® PX06012

polyamide 6



Starflam PX06012 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	• Release agent
Features	• Bromine Free	• 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	1.15	-	g/cm ³	ISO 1183
Water Absorption, 23°C, 24 hr	2.3	*	%	ISO 62
Outdoor Suitability	f2		-	UL 746C

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	3200	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	69	-	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	57	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.5	-	%	ISO 527-2
Flexural Modulus (23°C)	2500	-	MPa	ISO 178
Flexural Strength (23°C)	97	-	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	4	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	115	-	kJ/m ²	ISO 180/1U

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	58	-	°C	
0.45 MPa, Unannealed	164	-	°C	
RTI Elec				UL 746
0.750 mm	120		°C	
1.50 mm	120		°C	
3.00 mm	120		°C	

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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 0	-	

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