

Starflam® PX06091

polyamide 6



Starflam PX06091 is an unfilled, halogen free and red phosphorous free, flame retardant PA6 for injection molded applications.

General

Regional Availability	• North America	• Europe	
Additive	• Flame Retarding Agent	• Heat Stabilizer	• Release agent
Features	• Flame Retardant	• Halogen Content, None	
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.16	-	g/cm ³	ISO 1183

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

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	75	-	°C	
0.45 MPa, Unannealed	190	-	°C	
CLTE				ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	75	*	E-6/K	
Transverse : 23 to 55°C, 2.00 mm	80	*	E-6/K	
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

Starflam® PX06091

polyamide 6



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	dry	cond.	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	
Oxygen index	32	*	%	EN ISO 4589-2

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