

Starflam® RF0023E

copolyamide 66/6



Starflam RF0023E is a mineral filled, glass fiber reinforced, flame retardant (PA66+PA6)-blend 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	• Halogen Content, None	
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Water Absorption				ISO 62
23°C, 24 hr	0.6	*	%	
Equilibrium, 23°C, 50% RH	1.3	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	10700	5500	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	86	58	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	1.4	2.4	%	ISO 527-2
Flexural Modulus (23°C)	11100	5200	MPa	ISO 178
Flexural Strength (23°C)	137	81	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	3.6	4.1	kJ/m²	
-30°C	3.5	3.4	kJ/m²	
-40°C	3.5	3.3	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	21	34	kJ/m²	
-30°C	20	18	kJ/m²	
-40°C	20	18	kJ/m²	
Notched Izod Impact Strength				ISO 180/1A
+23°C	4	4.3	kJ/m²	
-30°C	3.6	3.4	kJ/m²	
-40°C	3.6	3.3	kJ/m²	
Unnotched Izod Impact Strength, +23°C	22	-	kJ/m²	ISO 180/1U

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Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	211	197	°C	
0.45 MPa, Unannealed	235	227	°C	
Melting Temperature	260	*	°C	ISO 11357-3
RTI Elec				UL 746
0.860 mm	130		°C	
1.70 mm	130		°C	
3.00 mm	130		°C	
RTI Imp				UL 746
0.860 mm	105		°C	
1.70 mm	105		°C	
3.00 mm	105		°C	
RTI Str				UL 746
0.860 mm	120		°C	
1.70 mm	130		°C	
3.00 mm	140		°C	
Electrical	dry	cond.	Unit	Test Standard
Dielectric Strength (1.00 mm)	25	24	kV/mm	IEC 60243
Comparative Tracking Index (3.00 mm)	600		V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.860 mm	PLC 0		-	
1.70 mm	PLC 0		-	
3.00 mm	PLC 0		-	
High Voltage Arc Tracking Rate (HVTR), 3.00 mm	PLC 0		-	UL 746
Hot-wire Ignition (HWI)				UL 746
0.860 mm	PLC 0		-	
Flammability	Value			Test Standard
Flammability				UL 94
0.860 mm	V-2			
1.70 mm	V-0			
3.00 mm	V-0			

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Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	≤ 0.2	%
Rear Temperature	270 - 280	°C
Middle Temperature	275 - 285	°C
Front Temperature	280 - 300	°C
Processing (Melt) Temperature	280 - 300	°C
Mold Temperature	60 - 90	°C

