

Starflam® RF0055E

copolyamide 66/6



Starflam RF0055E is a 25% 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	• Ignition Resistant
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.44	-	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	0.7	*	%	
Flow : 23°C, 2.00 mm	0.2	*	%	
Water Absorption				ISO 62
23°C, 24 hr	1.4	*	%	
Equilibrium, 23°C, 50% RH	1.7	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	10700	6900	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	141	87	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	1.8	2.3	%	ISO 527-2
Flexural Modulus (23°C)	10500	6500	MPa	ISO 178
Flexural Strength (23°C)	206	127	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	7.5	9.6	kJ/m ²	
-30°C	7.8	7	kJ/m ²	
-40°C	8.1	7.2	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	34	52	kJ/m ²	
-30°C	30	33	kJ/m ²	
-40°C	29	35	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
+23°C	8.2	8.6	kJ/m ²	

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-30°C	8.1	7.7	kJ/m²	
-40°C	7.9	7.2	kJ/m²	
Unnotched Izod Impact Strength, +23°C	40	-	kJ/m²	ISO 180/1U

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	222	211	°C	
0.45 MPa, Unannealed	241	238	°C	
Melting Temperature	255	*	°C	ISO 11357-3

Electrical	dry	cond.	Unit	Test Standard
Dielectric Strength (1.00 mm)	26	24	kV/mm	IEC 60243

Flammability	Value	Unit	Test Standard
Flammability			UL 94
0.860 mm	V-2	-	
1.70 mm	V-0	-	
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	850	°C	
1.50 mm	850	°C	
3.20 mm	850	°C	

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%
Rear Temperature	265 - 275	°C
Middle Temperature	265 - 275	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temperature	270 - 280	°C
Mold Temperature	60 - 100	°C

