

Starflam® X-Protect RF0023K

Ascend Performance Materials Operations LLC - Polyamide 66

General Information

Product Description

Starflam X-Protect RF0023K is a mineral flame retardant ,halogen free and red phosphorous free, glass fiber reinforced PA66 and PA6 for injection molded applications.

General

Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Flame Retardant • Heat Stabilizer • Mold Release
Features	• Bromine Free • Halogen Free • High Strength • Flame Retardant • Heat Stabilized
Agency Ratings	• ISO 1043 PA66 X (GF+MD)60 FR(61)
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID	• PA66-(X+GF)10 FR

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.74	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, 73°F)	13100	psi	ISO 527-2
Tensile Strain (Break, 73°F)	1.5	%	ISO 527-2
Flexural Modulus (73°F)	1.55E+6	psi	ISO 178
Flexural Stress (73°F)	21000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	1.4	ft·lb/in ²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	7.1	ft·lb/in ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	397	°F	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (0.118 in)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94
Glow Wire Flammability Index (0.06 in)	1760	°F	IEC 60695-2-12

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	< 140	°F
Drying Time	< 4.0	hr
Suggested Max Moisture	< 0.20	%
Rear Temperature	500 to 536	°F
Middle Temperature	518 to 536	°F
Front Temperature	482 to 518	°F
Nozzle Temperature	518 to 536	°F
Processing (Melt) Temp	500 to 536	°F
Mold Temperature	104 to 194	°F

