

STARAMIDE

A24G6K



DESCRIPTION Staramide A24G6K is an Easy Flow, Heat and Hydrolytically Stabilized, 35 % Glass Fiber Reinforced Polyamide 66 Injection Molding Resinjection

| PROPERTY (1) | UNIT | STANDARD | TYPICAL VALUE (1) Dry As Moulded |
|--------------|------|----------|-------------------------------------|
|--------------|------|----------|-------------------------------------|

PHYSICAL

| | | | |
|-------------------------------------|-------------------|------------|-----------|
| Density | g/cm ³ | ISO 1183 | 1.37 |
| Moisture Absorption (23°C / 50% RH) | % | ISO 62 | 1.2 |
| Mold Shrinkage on Tensile Bar, flow | % | E2P Method | 0.2 - 0.4 |
| Water Absorption, (23°C/sat) | % | ISO 62 | 4.5 |

MECHANICAL

| | | | |
|----------------------------------|-----|------------|------|
| Flexural Modulus, 2 mm/min | MPa | ISO 178 | 9000 |
| Flexural Stress, break, 2 mm/min | MPa | ISO 178 | 260 |
| Hardness, Rockwell L | | ISO 2039-2 | 114 |
| Tensile Modulus, 1 mm/min | MPa | ISO 527 | 9400 |
| Tensile Strain, break, 5 mm/min | % | ISO 527 | 3 |
| Tensile Stress, break, 5 mm/min | MPa | ISO 527 | 170 |

IMPACT

| | | | |
|---|-------------------|-------------|----|
| Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm | kJ/m ² | ISO 179/1eU | 75 |
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm | kJ/m ² | ISO 179/1eA | 8 |
| Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm | kJ/m ² | ISO 179/1eU | 55 |
| Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm | kJ/m ² | ISO 179/1eA | 7 |
| Izod Impact, notched 80*10*4 +23°C | kJ/m ² | ISO 180/1A | 8 |
| Izod Impact, notched 80*10*4 -20°C | kJ/m ² | ISO 180/1A | 7 |
| Izod Impact, notched 80*10*4 -40°C | kJ/m ² | ISO 180/1A | 6 |

Source RJF, last update 01-07-2010

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THERMAL

| | | | |
|---|--------|----------------|----------|
| Ball Pressure Test, 125°C +/- 2°C | | IEC 60695-10-2 | PASSES |
| CTE, 23°C to 60°C, flow | 1/°C | ISO 11359-2 | 2.50E-05 |
| CTE, 23°C to 60°C, xflow | 1/°C | ISO 11359-2 | 7.50E-05 |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm | °C | ISO 75/Ae | 250 |
| HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm | °C | ISO 75/Be | 260 |
| Relative Temp Index, Elec | °C | UL 746B | 110 |
| Relative Temp Index, Mech w/impact | °C | UL 746B | 95 |
| Relative Temp Index, Mech w/o impact | °C | UL 746B | 120 |
| Thermal Conductivity | W/m-°C | ISO 8302 | 0.33 |
| Vicat Softening Temp, Rate B/120 | °C | ISO 306 | 258 |
| Vicat Softening Temp, Rate B/50 | °C | ISO 306 | 260 |

FLAME CHARACTERISTICS

| | | | |
|--|--------|----------------|------|
| FMVSS Burning Speed, thickness 2 mm | mm/min | FMVSS 302 | 6 |
| FMVSS Burning Speed, thickness 3 mm | mm/min | FMVSS 302 | 2 |
| Glow Wire Flammability Index 650°C, passes at | mm | IEC 60695-2-12 | 2 |
| Oxygen Index (LOI) | % | ISO 4589 | 26 |
| UL Recognized, 94HB Flame Class Rating | mm | UL 94 | 0.75 |
| UL Recognized, 94HB Flame Class Rating 2nd value | mm | UL 94 | 3 |

ELECTRICAL

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ELECTRICAL

| | | | |
|-------------------------------------|--------|-------------|---------|
| Comparative Tracking Index | V | IEC 60112 | 500 |
| Comparative Tracking Index, M | V | IEC 60112 | 400 |
| Dielectric Strength, in oil, 3.2 mm | kV/mm | IEC 60243-1 | 20 |
| Dissipation Factor, 1 MHz | | IEC 60250 | 0.016 |
| Dissipation Factor, 50/60 Hz | | IEC 60250 | 0.007 |
| Relative Permittivity, 1 MHz | | IEC 60250 | 3.2 |
| Relative Permittivity, 50/60 Hz | | IEC 60250 | 3.4 |
| Surface Resistivity, ROA | Ohm | IEC 60093 | >1.E+16 |
| Volume Resistivity | Ohm-cm | IEC 60093 | >1.E+16 |

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| PARAMETER | SETTING | UNIT |
|-----------------------------|-----------|------|
| Drying Temperature | 75 - 85 | °C |
| Drying Time | 4 - 6 | hrs |
| Maximum Moisture Content | 0.2 | % |
| Mold Temperature | 60-90 | °C |
| Rear - Zone 1 Temperature | 260 - 280 | °C |
| Middle - Zone 2 Temperature | 270 - 280 | °C |
| Front - Zone 3 Temperature | 270 - 290 | °C |
| Melt Temperature | 270 - 290 | °C |

PROCESSING PARAMETERS: see above typical molding conditions.

DRYING: is not essential when material is delivered in sealed bags with moisture content below 0.2%.

BARRELS, SCREWS, MOULDS: use wear resisting steel or alloy such as bimetallic cylinders, nitrided screws.

USE OF REGRIND: the properties of the component should be checked in order to ascertain the maximum acceptable level of regrind.

SAFETY: please refer to Material Safety Datasheet

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