

DESCRIPTION Staramide A28 is an Unreinforced, Polyamide 66 Injection Molding Resin

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
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PHYSICAL

Density	g/cm ³	ISO 1183	1.14
Moisture Absorption (23°C / 50% RH)	%	ISO 62	2
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	1.6 - 2
Water Absorption, (23°C/sat)	%	ISO 62	8.5

MECHANICAL

Flexural Modulus, 2 mm/min	MPa	ISO 178	2800
Flexural Stress, yield, 2 mm/min	MPa	ISO 178	105
Tensile Modulus, 1 mm/min	MPa	ISO 527	3000
Tensile Strain, break, 50 mm/min	%	ISO 527	>20
Tensile Strain, yield, 50 mm/min	%	ISO 527	3.8
Tensile Stress, yield, 50 mm/min	MPa	ISO 527	85

IMPACT

Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eU	>270
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eA	5
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eU	>100
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eA	3
Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	5
Izod Impact, notched 80*10*4 -20°C	kJ/m ²	ISO 180/1A	4
Izod Impact, notched 80*10*4 -30°C	kJ/m ²	ISO 180/1A	3

Source RJF, last update 01-07-2010

(1) Typical values for natural color unless specified otherwise. Do not constitute a specification. Significant variations are possible for colors

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IMPACT

Izod Impact, notched 80*10*4 -40°C	kJ/m ²	ISO 180/1A	3
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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	8.00E-05
CTE, 23°C to 60°C, xflow	1/°C	ISO 11359-2	8.00E-05
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Ae	90
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Be	210

FLAME CHARACTERISTICS

Oxygen Index (LOI)	%	ISO 4589	26
UL E2P measurement, 94V-2 Flame Class Rating	mm	UL 94 by E2P	1.6

ELECTRICAL

Comparative Tracking Index	V	IEC 60112	600
Dielectric Strength, in oil, 3.2 mm	kV/mm	IEC 60243-1	16
Dissipation Factor, 1 MHz		IEC 60250	0.017
Dissipation Factor, 50/60 Hz		IEC 60250	0.0055
Relative Permittivity, 1 MHz		IEC 60250	2.9
Relative Permittivity, 50/60 Hz		IEC 60250	3.2
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 - 270	°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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