

**DESCRIPTION** Staramide ACF6 is a 30 % Carbon Fiber Reinforced Polyamide 66 injection Molding Resin

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

Density	g/cm <sup>3</sup>	ISO 1183	1.27
Mold Shrinkage on Tensile Bar, flow	%	E2P Method	0.04 - 0.08
Water Absorption, (23°C/sat)	%	ISO 62	4.5

### MECHANICAL

Flexural Modulus, 2 mm/min	MPa	ISO 178	19500
Flexural Stress, break, 2 mm/min	MPa	ISO 178	360
Hardness, Rockwell L		ISO 2039-2	108
Tensile Modulus, 1 mm/min	MPa	ISO 527	22000
Tensile Strain, break, 5 mm/min	%	ISO 527	2
Tensile Stress, break, 5 mm/min	MPa	ISO 527	250

### IMPACT

Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	kJ/m <sup>2</sup>	ISO 179/1eU	70
Izod Impact, notched 80*10*4 +23°C	kJ/m <sup>2</sup>	ISO 180/1A	8
Izod Impact, notched 80*10*4 -20°C	kJ/m <sup>2</sup>	ISO 180/1A	7
Izod Impact, notched 80*10*4 -40°C	kJ/m <sup>2</sup>	ISO 180/1A	6

### THERMAL

CTE, 23°C to 60°C, flow	1/°C	ISO 11359-2	1.40E-05
CTE, 23°C to 60°C, xflow	1/°C	ISO 11359-2	1.00E-04
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Ae	257

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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# STARAMIDE

## ACF6



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PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
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### THERMAL

HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Be	260
Vicat Softening Temp, Rate B/120	°C	ISO 306	255

### FLAME CHARACTERISTICS

Oxygen Index (LOI)	%	ISO 4589	27
UL E2P measurement, 94HB Flame Class Rating	mm	UL 94 by E2P	1.6

### ELECTRICAL

Surface Resistivity, ROA	Ohm	IEC 60093	4.32E+03
Volume Resistivity	Ohm-cm	IEC 60093	4.32E+03

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PARAMETER	SETTING	UNIT
Drying Temperature	75 - 85	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.2	%
Mold Temperature	70 - 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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