STARAMIDE

ACF6

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

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm^3	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^2	ISO 179/1eU	70
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
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

EUROSTAR Engineering Plastics, ZI - Rue de la Ferme Saint Ladre, BP2, F/95471 Fosses Cedex FRANCE,
Tel: + 33 1 34 47 47 00, Fax: + 33 1 34 47 47 18 - www.eurostar-ep.com

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