

DESCRIPTION Starflam A28UL is an Unfilled, Halogen Free and Red Phosphorous Free, Flame Retardant, 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
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MECHANICAL

Flexural Modulus, 2 mm/min	MPa	ISO 178	3400
Flexural Stress, break, 2 mm/min	MPa	ISO 178	130
Tensile Strain, break, 5 mm/min	%	ISO 527	3-5
Tensile Stress, break, 5 mm/min	MPa	ISO 527	88

IMPACT

Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	3
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THERMAL

CTE, 23°C to 60°C, flow	1/°C	ISO 11359-2	6.00E-05
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	86
Relative Temp Index, Mech w/impact	°C	UL 746B	90

FLAME CHARACTERISTICS

UL Recognized, 94V-2 Flame Class Rating	mm	UL 94	0.75
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ELECTRICAL

Comparative Tracking Index	V	IEC 60112	600
Surface Resistivity	Ohm	ASTM D 257	1.00E+16

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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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 - 280	°C
Melt Temperature	270 - 280	°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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