

DESCRIPTION Star X 1615 33V S4 is an Impact Modified, Glass Fiber Reinforced , UV stabilized Polyamide 66 Injection Molding Resin

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

Ash Content (650°C)	%	ISO 3451	33
Density	g/cm ³	ISO 1183	1.3
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	0.1-0.4

MECHANICAL

Flexural Modulus	MPa	ISO 178	6100
Flexural Stress	MPa	ISO 178	150
Tensile Modulus, 1 mm/min	MPa	ISO 527	7300
Tensile Strain, break	%	ISO 527	4-6
Tensile Stress, yield	MPa	ISO 527	115

IMPACT

Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eU	90
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	kJ/m ²	ISO 179/1eA	30
Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	30
Izod Impact, notched 80*10*4 -30°C	kJ/m ²	ISO 180/1A	18
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	90
Izod Impact, unnotched 80*10*4 -30°C	kJ/m ²	ISO 180/1U	85

THERMAL

HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	°C	ISO 75/Ae	230
Melting Point DSC	°C	ISO 3146	260

Source 99.258.71b BBi - RD

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

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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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PARAMETER	SETTING	UNIT
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
Drying Temperature	75 - 85	°C
Drying Time	4 - 6	hrs

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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