

STARAMIDE

6 70E3



DESCRIPTION Staramide 6 70E3 is a High Density Polyamide 6 Injection Molding Resin

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

Density	g/cm ³	ISO 1183	2.3
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	1.1 -1.4

MECHANICAL

Flexural Modulus	MPa	ISO 178	6800
Flexural Stress	MPa	ISO 178	103
Tensile Strain, break, 5 mm/min	%	ISO 527	1.3
Tensile Stress, break, 5 mm/min	MPa	ISO 527	77

IMPACT

Izod Impact, notched 80*10*4 +23°C	kJ/m ²	ISO 180/1A	3.1
Izod Impact, unnotched 80*10*4 +23°C	kJ/m ²	ISO 180/1U	18

THERMAL

HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	123
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Source LR3303 10 02 2011

(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
Maximum Moisture Content	0.2	%
Mold Temperature	80 - 95	°C
Rear - Zone 1 Temperature	250 - 260	°C
Middle - Zone 2 Temperature	275 - 290	°C
Melt Temperature	265 - 275	°C
Drying Temperature	80	°C
Drying Time	4	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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