

STARAMIDE, STAR T

6 80E10



DESCRIPTION Staramide 6 80E10 is a High Density Polyamide 6 Injection Molding Resin

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

Ash Content (650 °C)	%	ISO 3451	82
Density	g/cm ³	ISO 1183	4
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	1.1 - 1.3

MECHANICAL

Flexural Modulus, 2 mm/min	MPa	ISO 178	5400
Flexural Stress, break, 2 mm/min	MPa	ISO 178	90

IMPACT

Izod Impact, unnotched 80*10*4 +23 °C	kJ/m ²	ISO 180/1U	25
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THERMAL

HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	84
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Source LR3655

(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 - 110	°C
Rear - Zone 1 Temperature	250 - 260	°C
Middle - Zone 2 Temperature	260 - 280	°C
Front - Zone 3 Temperature	260 - 280	°C
Melt Temperature	260 - 280	°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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