

LNP Starflam* PF-1004 Z222

SABIC Innovative Plastics Asia Pacific - Polyamide 6

General Information

General

Filler / Reinforcement	• Glass Fiber Reinforcement		
Features	• Bromine Free	• Chlorine Free	• Flame Retardant
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM and ISO Properties ¹

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.35 g/cm ³	1.35 g/cm ³	ISO 1183
Molding Shrinkage (Flow, 24 hr)	0.30 to 0.60 %	0.30 to 0.60 %	ISO 294-4
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.09E+6 psi	7500 MPa	ISO 527-2
Tensile Stress (Break)	13100 psi	90.0 MPa	ISO 527-2
Tensile Strain (Break)	2.5 %	2.5 %	ISO 527-2
Flexural Modulus	725000 psi	5000 MPa	ISO 178
Flexural Strength	18900 psi	130 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact Strength	2.86 ft-lb/in ²	6.00 kJ/m ²	ISO 180
Unnotched Izod Impact Strength	14.3 ft-lb/in ²	30.0 kJ/m ²	ISO 180
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature 264 psi (1.8 MPa), Unannealed	284 °F	140 °C	ISO 75-2/A
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating - UL (0.0295 in (0.750 mm))	V-2	V-2	UL 94
Additional Properties			
Tensile Strain @ Break, ISO 527: 2 to 3%			

Processing Information

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 °F	82.2 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.020 %	0.020 %
Processing (Melt) Temp	485 to 510 °F	252 to 266 °C
Mold Temperature	130 to 200 °F	54.4 to 93.3 °C
Back Pressure	25.0 to 50.0 psi	0.172 to 0.345 MPa

Notes

¹ Typical properties: these are not to be construed as specifications.