

Durethan DPBM65XFM30 000000 DUS013

PA 6, 65 % mineral/glass fibres, injection molding, halogen free flame retardant, improved flowability despite the high degree of filling, optimized for laser marking (1064nm), heat-aging stabilized

ISO Shortname: ISO 16396-PA 6,(MD+GF)65 FR(61),GF2HR,S14-120

Property	Test Condition	Unit	Standard	guide value d.a.m.	cond.
Rheological properties					
C Molding shrinkage, parallel	60x60x2; 280 °C / MT 80 °C; 500 bar	%	ISO 294-4	0.4	
C Molding shrinkage, transverse	60x60x2; 280 °C / MT 80 °C; 500 bar	%	ISO 294-4	0.5	
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1	
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1	
Mechanical properties (23 °C/50 % r. h.)					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	12100	6000
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	120	73
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	1.6	2.2
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	30	23
Izod impact strength	23 °C	kJ/m ²	ISO 180-1U	25	22
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-1A	<10	<10
Flexural modulus	2 mm/min	MPa	ISO 178-A	12300	6000
Flexural strength	2 mm/min	MPa	ISO 178-A	175	110
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	1.8	2.6
Thermal properties					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	220	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	181	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	200	
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	204	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.3	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.5	
Thermal conductivity, in-plane		W/(m·K)	ISO 22007-4	1.1	
Thermal conductivity, through-plane		W/(m·K)	ISO 22007-4	0.9	
C Burning behavior UL 94	1.5 mm	Class	UL 94	V-0	
Burning behavior UL 94	1.2 mm	Class	UL 94	V-0	
C Oxygen index	Method A	%	ISO 4589-2	49.1	
Glow wire test (GWFI)	0.8 mm	°C	IEC 60695-2-12	960	
Glow wire test (GWIT)	0.8 mm	°C	IEC 60695-2-13	775	
Electrical properties (23 °C/50 % r. h.)					
C Electric strength	1 mm	kV/mm	IEC 60243-1	26.3	
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	600	
Other properties (23 °C)					
C Density		kg/m ³	ISO 1183	1690	
Processing conditions for test specimens					
C Injection molding-Melt temperature		°C	ISO 294	260	
C Injection molding-Mold temperature		°C	ISO 294	80	



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Processing recommendations						
Drying temperature dry air dryer		°C	-	80		
Drying time dry air dryer		h	-	2-6		
Residual moisture content		%	Acc. to Karl Fischer	0.03-0.07		
Melt temperature (Tmin - Tmax)		°C	-	250-280		
Mold temperature		°C	-	80-100		

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.



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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

Conditioning

Conditioning in accordance with ISO 1110 (70 °C; 62 % r.h.)

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