

Durethan® BM25FN20 700350

PA6—MX25 FR(30)

25% Mineral Reinforced, Injection Molding, Flame Retardant (halogen free), Heat Stabilized

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.9 / *	%	ISO 294-4
Molding shrinkage (normal)	0.9 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	6200 / 2300	MPa	ISO 527-1/-2
Stress at break	80 / 35	MPa	ISO 527-1/-2
Strain at break	2.2 / 11	%	ISO 527-1/-2
Flexural modulus	5500 / 2000	MPa	ISO 178
Flexural strength	135 / 50	MPa	ISO 178
Charpy impact strength (+23°C)	38 / 135	kJ/m²	ISO 179/1eU
Izod notched impact strength (+23°C)	<10 / <10	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	90 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	195 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.6 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	0.7 / *	E-4/°C	ISO 11359-1/-2
Burning Behav. at 1.5 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.75 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10

Property Data

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	0.75 / –	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	1.5 / –	mm	IEC 60695-2-12
Glow Wire Ignition Temperature GWIT	725 / –	°C	IEC 60695-2-13
GWIT (Thickness (1) tested)	0.75 / –	mm	IEC 60695-2-13
Glow Wire Ignition Temperature GWIT	725 / –	°C	IEC 60695-2-13
GWIT (Thickness (2) tested)	1.5 / –	mm	IEC 60695-2-13

OTHER PROPERTIES	DRY / COND		
Water absorption	6.7 / *	%	Sim. to ISO 62
Density	1380 / –	kg/m³	ISO 1183

PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	250-270	°C	
Mold temperature	80-100	°C	