

Durethan® DPBM65XFM30 901510
PA6-(GF+MX)65 FR(61)

Envalior

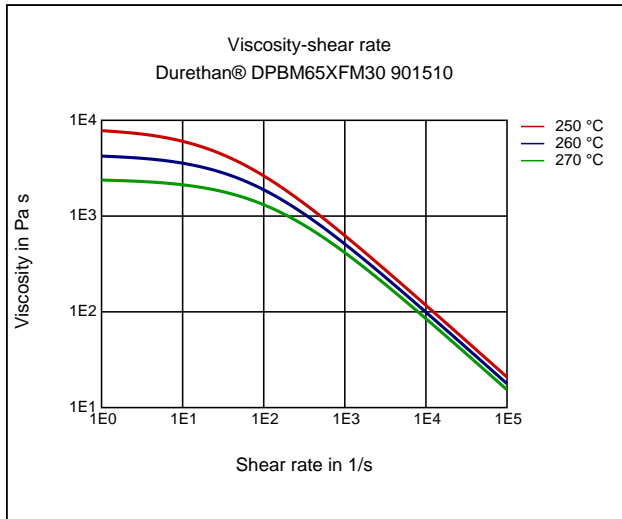
Injection Molding, 65% Glass/Mineral Reinforced, Flame Retardant (halogen free), Heat Stabilized, Improved flow

ISO 1043 PA6-(GF+MX)65 FR(61)

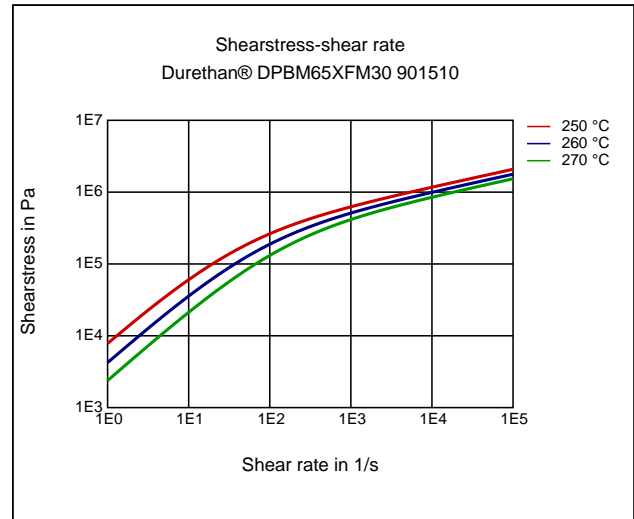
Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5 / *	%	ISO 294-4, 2577
Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	12100 / 6000	MPa	ISO 527
Stress at Break	120 / 73	MPa	ISO 527
Strain at Break	1.6 / 2.2	%	ISO 527
Impact Strength (Charpy), +23°C	30 / 23	kJ/m ²	ISO 179/1eU
Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	181 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	200 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	50 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	3.0 / *	mm	-
Oxygen index	49.1 / *	%	ISO 4589-1/-2
Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Electric Strength	26.3 / -	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	3.5 / *	%	Sim. to ISO 62
Humidity absorption	1.2 / *	%	Sim. to ISO 62
Density	1690 / -	kg/m ³	ISO 1183
Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

Viscosity-shear rate



Shearstress-shear rate



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 250 - 280 °C

Mold temperature: 80 - 100 °C

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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- any critical component in any medical device that supports or sustains human life.

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