

Durethan® B30SF 000000

PA6

Envalior

Injection Molding, Unreinforced, Food Contact Quality

ISO 1043 PA6

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	3200 / 1000	MPa	ISO 527
Yield stress	80 / 40	MPa	ISO 527
Yield strain	4 / 20	%	ISO 527
Nominal strain at break	20 / >50	%	ISO 527
Tensile Creep Modulus, 1h	* / 800	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 600	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	no break / no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break / no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 20	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	5140 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	6540 / -	N	ISO 6603-2
Puncture energy, +23°C	12 / -	J	ISO 6603-2
Puncture energy, -30°C	10 / -	J	ISO 6603-2
Flexural Modulus (23°C)	2900 / 850	MPa	ISO 178
Flexural strength	110 / 35	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / 10	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	no break / no break	kJ/m²	ISO 180/1U
Ball Indentation Hardness	140 / 50	MPa	ISO 2039-1

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	55 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	160 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	100 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	110 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-2 / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Oxygen index	26 / *	%	ISO 4589-1/-2
Glow Wire (GWFI, Flammability Index)	750	°C	IEC 60695-2-12

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4 / 15	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.5 / 4	-	IEC 62631-2-1
Dissipation Factor, 100Hz	170 / 2000	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	200 / 1200	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E13	Ohm	IEC 62631-3-2
Electric Strength	30 / 30	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	10 / *	%	Sim. to ISO 62
Humidity absorption	3 / *	%	Sim. to ISO 62
Density	1140 / -	kg/m³	ISO 1183
Bulk density	700	kg/m³	-

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	134 / *	cm³/g	ISO 307, 1157, 1628

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Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°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	≤0.12	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Certifications

Food approval

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 260 - 280 °C

Mold temperature: 80 - 100 °C