

Durethan T40 000000

PA 6I, non-reinforced, injection molding, extrusion

ISO/ ASTM

ISO Shortname: ISO 16396-PA 6I,,GT,S12-030

Property	Test Condition	Unit	Standard	guide value	
				d.a.m.	cond.
Rheological properties					
Molding shrinkage, parallel	150x105x3; 270 °C / WZ 80 °C; 500% bar		acc. ISO 2577	0.53	
Molding shrinkage, transverse	150x105x3; 270 °C / WZ 80 °C; 500% bar		acc. ISO 2577	0.49	
Post- shrinkage, parallel	150x105x3; 100 °C; 4 h	%	acc. ISO 2577	0.13	
Post- shrinkage, transverse	150x105x3; 100 °C; 4 h	%	acc. ISO 2577	0.09	
Mechanical properties (23 °C/50 % r. h.)					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	3300	3000
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	110	90
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.0	5.0
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	N	N
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179-1eU	N	N
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179-1eA	< 10	< 10
C Charpy notched impact strength	-30 °C	kJ/m ²	ISO 179-1eA	< 10	< 10
Charpy notched impact strength	-40 °C	kJ/m ²	ISO 179-1eA	< 10	< 10
Izod notched impact strength	-30 °C	kJ/m ²	ISO 180-1A	< 10	< 10
Izod notched impact strength	-40 °C	kJ/m ²	ISO 180-1A	< 10	< 10
Flexural modulus	2 mm/min	MPa	ISO 178-A	3000	3000
Flexural strength	2 mm/min	MPa	ISO 178-A	150	130
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	7.0	5.0
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	105	110
Thermal properties					
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	105	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	115	
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	125	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.7	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.8	
C Burning behavior UL 94	1.5 mm	Class	UL 94	V-2	
C Burning behavior UL 94	0.75 mm	Class	UL 94	V-2	
Glow wire test (GWFI)	2.0 mm	°C	IEC 60695-2-12	960	
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	125	
Electrical properties (23 °C/50 % r. h.)					
C Relative permittivity	100 Hz	-	IEC 60250	4.3	4.6
C Relative permittivity	1 MHz	-	IEC 60250	3.8	4.0
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	400	480
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	900	1100
C Volume resistivity		Ohm·m	IEC 60093	1E13	1E13
C Surface resistivity		Ohm	IEC 60093	1E15	1E15
C Electric strength	1 mm	kV/mm	IEC 60243-1	25	28
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	600	
Other properties (23 °C)					
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	6.0	
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	2.0	
C Density		kg/m ³	ISO 1183	1180	
Processing conditions for test specimens					
C Injection molding-Melt temperature		°C	ISO 294	270	
C Injection molding-Mold temperature		°C	ISO 294	80	
Processing recommendations					
Drying temperature dry air dryer		°C	-	80	
Drying time dry air dryer		h	-	2-6	
Residual moisture content		%	Acc. to Karl Fischer	0.03-0.12	

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

Disclaimer

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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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