

Durethan® B 24 CM H2.0 901510

Polyamide 6

LANXESS GmbH

Message:

PA 6, non-reinforced, compression molding, reduced emission during processing

General Information				
Features		Low Emissions		
Processing Method		Compression Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.13	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 260°C, 2.00 mm ¹	1.4	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.40	--	%	
Flow : 260°C, 2.00 mm ³	1.3	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.40	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3400	1000	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	80.0	--	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	3.6	--	%	ISO 527-2/50
Flexural Modulus ⁵ (23°C)	3000	950	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain, 23°C	100	25.0	MPa	
23°C ⁶	120	40.0	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	5.8	9.5	%	ISO 178/A
ISO Shortname	PA 6, GR, 10-030	--		ISO 1874
Residual Moisture Content	0.030 to 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	< 10	--	kJ/m ²	
23°C	< 10	24	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)				ISO 179/1eU
Notched Izod Impact Strength				ISO 180/1A
-30°C	< 10	--	kJ/m ²	
23°C	< 10	23	kJ/m ²	

Unnotched Izod Impact Strength (23°C)	No Break	No Break		ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	66.0	--	°C	ISO 75-2/A
Melting Temperature ⁸	220	--	°C	ISO 11357-3
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 to 6.0		hr	
Processing (Melt) Temp	250 to 280		°C	
Mold Temperature	80.0 to 100		°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 bar			
4.	60x60x2mm			
5.	2.0 mm/min			
6.	2.0 mm/min			
7.	2 mm/min			
8.	10°C/min			

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