Durabio™ D6350

PC — Mitsubishi Chemical Performance Polymers

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**9**	cm³/10min	ISO 1133
Temperature	**230**	°C	-
Load	**2.16**	kg	-
Melt flow index, MFI	**12**	g/10min	ISO 1133
Temperature	**230**	°C	-
Load	**2.16**	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2200**	MPa	ISO 527
Tensile Strength	**70**	MPa	ISO 527
Strain at break	**110**	%	ISO 527
Flexural modulus, 23°C	**2500**	MPa	ISO 178
Flexural strength	**95**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**8**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**90**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**101**	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**71**	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**71**	E-6/K	ISO 11359-1/-2

Optical properties	Value	Unit	Test Standard
ISO Data			
Luminous transmittance	**92**	%	ISO 13468-1, -2

Other properties	Value	Unit	Test Standard
Density	**1340**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Time	**5 - 7**	h	-
Melt temperature	**230 - 250**	°C	-
Mold temperature	**60 - 80**	°C	-
Feed temperature	**220 - 260**	°C	-
Zone 1	**220 - 260**	°C	-
Nozzle temperature	**220 - 260**	°C	-
Screw speed	**50**	rpm	-
Injection pressure	**50 - 95**	MPa	-
Back pressure	**10**	MPa	-

Characteristics

Processing
Injection Molding

Delivery form
Black

Special Characteristics
Transparent

Certifications
Contains renewable resources

Applications
Automotive, Electrical and Electronical, Packaging, Sports Equipment

Regional Availability
North America, Europe, Asia Pacific

Features
Light Guiding