

**DURANEX® 930MA**

(PBT+PET)-GF25

Polyplastics

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Strength	<b>127</b>	MPa	ISO 527
Strain at break	<b>3.5</b>	%	ISO 527
Flexural modulus, 23°C	<b>7200</b>	MPa	ISO 178
Flexural strength	<b>195</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>11</b>	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>205</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Yellow Card available	<b>yes</b>	-	-

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1470</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>140</b>	°C	-
Pre-drying - Time	<b>3</b>	h	-
Mold temperature	<b>140 - 150</b>	°C	-
Zone 1	<b>230 - 250</b>	°C	-
Zone 2	<b>240 - 270</b>	°C	-
Zone 3	<b>250 - 275</b>	°C	-
Zone 4	<b>260 - 275</b>	°C	-
Nozzle temperature	<b>260 - 275</b>	°C	-
Screw speed	<b>100 - 150</b>	rpm	-
Back pressure	<b>1 - 5</b>	MPa	-
Holding pressure	<b>60 - 100</b>	MPa	-

**Characteristics****Features**

Good Adhesion

**Regional Availability**

Asia Pacific