

DuraStar™ MN611

Thermoplastic Polyester
Eastman Chemical Company

Message:

Durastar™ Polymer MN611 has been tested for FDA/ISO 10993 and USP Class VI Biological Evaluation testing after Gamma and EtO sterilization. It contains a mold release to improve ejection. It has excellent appearance and is nearly water-clear. Its most outstanding features are toughness, chemical resistance, and excellent processing characteristics. MN611 has very good toughness.

General Information			
Additive	Mold Release		
Features	E-beam Sterilizable		
	Good Chemical Resistance		
	Good Mold Release		
	Good Processability		
	Good Toughness		
	High Clarity		
	Pleasing Surface Appearance		
	Radiation Sterilizable		
Uses	Medical/Healthcare Applications		
Agency Ratings	ISO 10093		
	USP Class VI		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	103		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1800	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	47.0	MPa	ASTM D638, ISO 527-2
Break, 23°C	51.0	MPa	ASTM D638
Break, 23°C	46.0	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	5.0	%	ASTM D638
Yield, 23°C	4.0	%	ISO 527-2
Break, 23°C	300	%	ASTM D638

Break, 23°C	200	%	ISO 527-2
Flexural Modulus			
23°C	2000	MPa	ASTM D790
23°C	1850	MPa	ISO 178
Flexural Stress			
23°C	65.0	MPa	ISO 178
Yield, 23°C	69.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-40°C	40	J/m	ASTM D256
23°C	80	J/m	ASTM D256
-40°C	4.8	kJ/m ²	ISO 180
23°C	7.8	kJ/m ²	ISO 180
Unnotched Izod Impact			ASTM D4812
-40°C	No Break		
23°C	No Break		
Instrumented Dart Impact			ASTM D3763
-40°C, Energy at Peak Load	48.0	J	
23°C, Energy at Peak Load	42.0	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	74.0	°C	
1.8 MPa, Unannealed	65.0	°C	
Optical	Nominal Value	Unit	Test Method
Transmittance			ASTM D1003
Total	91.0	%	
Regular	89.0	%	
Haze	0.30	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	71.0	°C	
Drying Time	3.0 to 4.0	hr	
Processing (Melt) Temp	232 to 277	°C	
Mold Temperature	16.0 to 38.0	°C	

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