

DURANEX® 711SA

Acrylonitrile Butadiene Styrene + PBT

Polyplastics Co., Ltd.

Message:

Low Warpage, SA Series, for ODD and OA chassis, GF reinforced, Low gravity, Low wear

General Information			
UL YellowCard	E213445-228854		
Filler / Reinforcement	Glass/mica, 30% filler by weight		
Features	Low density		
	Low warpage		
	Good wear resistance		
UL File Number	E213445		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBT+ABS-(GF+PS) 30		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Water Absorption (23°C, 24 hr)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	93.0	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	7620	MPa	ISO 178
Flexural Stress	130	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	5.3	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	180	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	3.0E-5	cm/cm/°C	Internal method
Lateral: 23 to 55°C	6.0E-5	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.00 mm)	26	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	EF2001/ED3002		
Injection	Nominal Value	Unit	

Drying Temperature	120 - 140	°C
Drying Time	3.0 - 5.0	hr
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	40.0 - 80.0	°C
Holding Pressure	60.0 - 100	MPa
Screw Speed	100 - 150	rpm

Injection instructions

Cooling Time: Plasticization time + alpha or time without sticking in mold

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