

Mitsubishi Chemical Advanced Materials Duratron® PAI T4540 Polyamide-imide, compression molded (ASTM Product Data Sheet)
Categories: Polymer; Thermoplastic; Polyamide-imide (PAI); Polyamide-Imide, Molded

Material Notes: Quadrant Engineering Plastic Products is now Mitsubishi Chemical Advanced Materials.

Physical Properties	Metric	English	Comments
Specific Gravity	1.46 g/cc	1.46 g/cc	ASTM D792
Water Absorption	0.30 %	0.30 %	Immersion, 24hr; ASTM D570(2)
Water Absorption at Saturation	1.5 %	1.5 %	Immersion; ASTM D570(2)

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell E	76	76	ASTM D785
Hardness, Rockwell M	114	114	ASTM D785
Hardness, Shore D	90	90	ASTM D2240
Tensile Strength	62.1 MPa	9000 psi	ASTM D638
Tensile Strength at 150°C (300°F)	37.2 MPa	5400 psi	ASTM D638
Tensile Strength at 65°C (150°F)	55.2 MPa	8000 psi	ASTM D638
Elongation at Break	2.5 %	2.5 %	ASTM D638
Tensile Modulus	4.14 GPa	600 ksi	ASTM D638
Flexural Strength	89.6 MPa	13000 psi	ASTM D790
Flexural Modulus	3.79 GPa	550 ksi	ASTM D790
Compressive Strength	152 MPa	22000 psi	10% Def.; ASTM D695
Compressive Modulus	2.41 GPa	350 ksi	ASTM D695
Izod Impact, Notched	0.587 J/cm	1.10 ft-lb/in	ASTM D256 Type A
Coefficient of Friction, Dynamic	0.20	0.20	Dry vs. Steel; QTM55007
K (wear) Factor	635 x 10 ⁻⁸ mm ³ /N-M	315 x 10 ⁻¹⁰ in ³ -min/ft-lb-hr	QTM 55010
Limiting Pressure Velocity	0.263 MPa-m/sec	7500 psi-ft/min	4:1 safety factor; QTM 55007

Electrical Properties	Metric	English	Comments
Surface Resistivity per Square	>= 1.00e+13 ohm	>= 1.00e+13 ohm	EOS/ESD S11.11

Thermal Properties	Metric	English	Comments
CTE, linear	36.0 µm/m-°C @Temperature -40.0 - 149 °C	20.0 µin/in-°F @Temperature -40.0 - 300 °F	ASTM E831
Thermal Conductivity	0.405 W/m-K	2.81 BTU-in/hr-ft ² -°F	ASTM E 1530-11
Maximum Service Temperature, Air	260 °C	500 °F	Long Term
Deflection Temperature at 1.8 MPa (264 psi)	279 °C	534 °F	ASTM D648
Glass Transition Temp, Tg	275 °C	527 °F	ASTM D3418
Flammability, UL94	V-0 @Thickness 3.17 mm	V-0 @Thickness 0.125 in	Estimated Rating

Compliance Properties	Metric	English	Comments
3A-Dairy	No	No	
Canada AG	No	No	
FDA	No	No	
NSF	No	No	
USDA	No	No	
USP Class VI	No	No	

Chemical Resistance Properties	Metric	English	Comments
Acids, Strong (pH 1-3)	Limited	Limited	
Acids, Weak	Acceptable	Acceptable	
Alcohols	Acceptable	Acceptable	
Alkalies, Strong (pH 11-14)	Unacceptable	Unacceptable	
Alkalies, Weak	Limited	Limited	
Chlorinated Solvents	Acceptable	Acceptable	
Conductive / Static Dissipative	No	No	
Continuous Sunlight	Acceptable	Acceptable	
Hot Water / Steam	Limited	Limited	
Hydrocarbons - Aliphatic	Acceptable	Acceptable	
Hydrocarbons - Aromatic	Acceptable	Acceptable	
Inorganic Salt Solutions	Acceptable	Acceptable	

Descriptive Properties

Machinability

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1-10, 1=Easier to Machine



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