

**Material Data Sheet: DURAFORM EX**

**Properties:** High impact resistance with extreme toughness, excellent for use with living hinge applications.

**TECHNICAL DATA****General Properties**

MEASUREMENT	METHOD/CONDITION	METRIC	U.S.
Specific Gravity	ASTM D792	1.01 g/cm <sup>3</sup>	1.01 g/cm <sup>3</sup>
Moisture Absorption - 24 hours	ASTM D570	0.48%	0.48%
Moisture Saturation	ASTM D570	1.15%	1.15%

**Mechanical Properties**

MEASUREMENT	METHOD/CONDITION	METRIC	U.S.
Tensile Strength, Yield	ASTM D638	37 MPa	5366 psi
Tensile Strength, Ultimate	ASTM D638	48 MPa	6961 psi
Tensile Modulus	ASTM D638	1517 MPa	220 ksi
Elongation at Yield	ASTM D638	5%	5%
Elongation at Break	ASTM D638	47%	47%
Flexural Strength, Yield	ASTM D790	42 MPa	6091 psi
Flexural Strength, Ultimate	ASTM D790	46 MPa	6672 psi
Flexural Modulus	ASTM D790	1310 MPa	190 ksi
Hardness, Shore D	ASTM D2240	74	74
Hardness, Rockwell L	ASTM D785	69	69
Hardness, Rockwell M	ASTM D785	34	34
Impact Strength (notched Izod, 23°C)	ASTM D256	74 J/m	1.4 ft-lb/in
Impact Strength (unnotched Izod, 23°C)	ASTM D256	1486 J/m	27.8 ft-lb/in
Gardner Impact	ASTM D5420	11.8 J	8.7 ft-lb

**Thermal Properties**

MEASUREMENT	METHOD/CONDITION	METRIC	U.S.
Heat Deflection Temperature (HDT)	ASTM D648 @ 0.45 MPa	188 °C	370 °F
	@ 1.82 MPa	48 °C	118 °F
Coefficient of Thermal Expansion	ASTM E831 @ 0 - 50 °C	120 µm/m-°C	66.7 µin/in-°F
	@ 85 - 145 °C	342 µm/m-°C	190 µin/in-°F
Specific Heat Capacity	ASTM E1269	1.75 J/g-°C	0.418 BTU/lb-°F
Thermal Conductivity	ASTM E1225	0.51 W/m-K	3.5 BTU-in/hr-ft <sup>2</sup> -°F
Flammability	UL 94	HB	HB

**Electrical Properties**

MEASUREMENT	METHOD/CONDITION	METRIC	U.S.
Volume Resistivity	ASTM D257	1.3 X 10 <sup>13</sup> ohm-cm	1.3 X 10 <sup>13</sup> ohm-cm
Surface Resistivity	ASTM D257	4.9 X 10 <sup>12</sup> ohm	4.9 X 10 <sup>12</sup> ohm
Dissipation Factor, 1 KHz	ASTM D150	0.050	0.050
Dielectric Constant, 1 KHz	ASTM D150	4.5	4.5
Dielectric Strength	ASTM D149	18.5 kV/mm	470 kV/in

Data was generated by building parts under typical default parameters. DuraForm EX plastic was processed on a base-level HIQ SLS system at 13 watts laser power, 200 inches/sec [5 m/sec] scan speed, and a powder layer thickness of 0.004 inches [0.1 mm].