

Durethan® AKV25FN00

(PA66+PA6)—GF25 FR(40+72)

25% Glass Reinforced, Injection Molding, Heat Stabilized, Flame Retardant (halogen free)

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294-4
Molding shrinkage (normal)	0.9 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	9600 / 5800	MPa	ISO 527-1/-2
Stress at break	125 / 80	MPa	ISO 527-1/-2
Strain at break	3 / 6	%	ISO 527-1/-2
Flexural modulus	9100 / 5700	MPa	ISO 178
Flexural strength	210 / 135	MPa	ISO 178
Charpy impact strength (+23°C)	60 / 65	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	60 / 60	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / <10	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / <10	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	225 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.4 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.4 / *	mm	IEC 60695-11-10



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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Burning Behav. at 0.75 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Oxygen index	38 / *	%	ISO 4589-1/-2
Glow Wire Flammability Index GWFI	960 / -	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	0.4 / -	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / -	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	0.75 / -	mm	IEC 60695-2-12
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (1) tested)	0.4 / -	mm	IEC 60695-2-13
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (2) tested)	0.75 / -	mm	IEC 60695-2-13

ELECTRICAL PROPERTIES	DRY / COND		
Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Electric strength	35 / -	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	V	IEC 60112

OTHER PROPERTIES	DRY / COND		
Water absorption	4.6 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1390 / -	kg/m³	ISO 1183

PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	265-285	°C	
Mold temperature	80-100	°C	

