

Durethan® AKV35LTH3.0

PA66—GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized, Laser Transparent Black

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	11000 / 7500	MPa	ISO 527-1/-2
Stress at break	195 / 125	MPa	ISO 527-1/-2
Strain at break	3 / 5.5	%	ISO 527-1/-2
Flexural modulus	10000 / 7800	MPa	ISO 178
Flexural strength	295 / 214	MPa	ISO 178
Charpy impact strength (+23°C)	65 / 80	kJ/m²	ISO 179/1eU
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	230 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.2 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	0.7 / *	E-4/°C	ISO 11359-1/-2
OTHER PROPERTIES			
	DRY / COND		
Density	1400 / -	kg/m³	ISO 1183
PROCESSING RECOMMENDATIONS			
	VALUE		
Drying temperature dry air dryer	80	°C	



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Drying time dry air dryer	2–6	h	
Residual moisture content	0.03–0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	280–300	°C	
Mold temperature	80–120	°C	

