

# Durethan® AM230ZH3.0

## PA66—I—MX30

30% Mineral Reinforced, Injection Molding, Heat Stabilized, Improved Impact, Low Warpage

| PROPERTIES                                | TYPICAL DATA | UNIT  | TEST METHOD  |
|-------------------------------------------|--------------|-------|--------------|
| <b>RHEOLOGICAL PROPERTIES</b>             |              |       |              |
|                                           | DRY / COND   |       |              |
| Molding shrinkage (parallel)              | 1.7 / *      | %     | ISO 294-4    |
| Molding shrinkage (normal)                | 1.6 / *      | %     | ISO 294-4    |
| <b>MECHANICAL PROPERTIES</b>              |              |       |              |
|                                           | DRY / COND   |       |              |
| Tensile modulus                           | 3700 / –     | MPa   | ISO 527-1/-2 |
| Stress at break                           | 60 / –       | MPa   | ISO 527-1/-2 |
| Strain at break                           | 15 / –       | %     | ISO 527-1/-2 |
| Flexural modulus                          | 3600 / –     | MPa   | ISO 178      |
| Flexural strength                         | 105 / –      | MPa   | ISO 178      |
| Charpy impact strength (+23°C)            | 250 / –      | kJ/m² | ISO 179/1eU  |
| Charpy impact strength (-30°C)            | 200 / –      | kJ/m² | ISO 179/1eU  |
| Charpy notched impact strength (+23°C)    | 10 / –       | kJ/m² | ISO 179/1eA  |
| Charpy notched impact strength (-30°C)    | <10 / –      | kJ/m² | ISO 179/1eA  |
| Izod notched impact strength (+23°C)      | 10 / –       | kJ/m² | ISO 180/1A   |
| <b>THERMAL PROPERTIES</b>                 |              |       |              |
|                                           | DRY / COND   |       |              |
| Temp. of deflection under load (1.80 MPa) | 75 / *       | °C    | ISO 75-1/-2  |
| Temp. of deflection under load (0.45 MPa) | 190 / *      | °C    | ISO 75-1/-2  |
| <b>OTHER PROPERTIES</b>                   |              |       |              |
|                                           | DRY / COND   |       |              |
| Density                                   | 1330 / –     | kg/m³ | ISO 1183     |

### PROCESSING RECOMMENDATIONS

### VALUE



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| PROPERTIES                       | TYPICAL DATA | UNIT | TEST METHOD          |
|----------------------------------|--------------|------|----------------------|
| Drying temperature dry air dryer | 80           | °C   |                      |
| Drying time dry air dryer        | 4            | h    |                      |
| Residual moisture content        | 0.03–0.12    | %    | acc. to Karl Fischer |
| Melt temperature (Tmin – Tmax)   | 280–300      | °C   |                      |
| Mold temperature                 | 80–100       | °C   |                      |

