

Durethan® DP2325H3.0 DUS031

PA66—I

Injection Molding, Unreinforced, Heat Stabilized, Improved flow, Improved Impact

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	1.9 / *	%	ISO 294-4
Molding shrinkage (normal)	1.7 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	1850 / 650	MPa	ISO 527-1/-2
Nominal strain at break	>50 / -	%	ISO 527-1/-2
Yield stress	48 / 30	MPa	ISO 527-1/-2
Yield strain	15 / 35	%	ISO 527-1/-2
Flexural modulus	1800 / 700	MPa	ISO 178
Flexural strength	70 / 30	MPa	ISO 178
Charpy impact strength (+23°C)	N / N	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	N / N	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	80 / 100	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	20 / 20	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	75 / 100	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	60 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	140 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	1.5 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.3 / *	E-4/°C	ISO 11359-1/-2



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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
OTHER PROPERTIES	DRY / COND		
Water absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1070 / –	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	0.03–0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	270–290	°C	
Mold temperature	80–90	°C	
admissible residence time at Tmax	<10	min	

