Property Data

Envalior
Imagine the Future

Durethan® DPAKV30HREF

PA66–GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized, Hydrolysis resistant, Improved flow

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.37 / *	%	ISO 294–4
Molding shrinkage (normal)	0.82 / *	%	ISO 294–4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	8200 / 5000	MPa	ISO 527–1/–2
Stress at break	150 / 100	MPa	ISO 527–1/–2
Strain at break	3.6 / 8	%	ISO 527–1/–2
Flexural modulus	8100 / 5000	MPa	ISO 178
Flexural strength	240 / 150	MPa	ISO 178
Tensile modulus (200°C)	3420	MPa	ISO 527–1/–2
Charpy impact strength (+23°C)	80 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength (–30°C)	70 / –	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 / 15	kJ/m²	ISO 180/1A
THERMAL PROPERTIES	DRY / COND		
Melting temperature (10°C/min)	263 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	240 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75–1/–2
OTHER PROPERTIES	DRY / COND		
Density	1320 / –	kg/m³	ISO 1183

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PROPERTIES	*TYPICAL DATA*	*UNIT*	*TEST METHOD*
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)	280–300	°C	
Mold temperature	80–120	°C	