

Durethan® DP1852/30

PA6-GF30

Envalior

PA 6, 30 % glass fibres, injection moulding, flame retardant

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	33 / *	cm ³ /10min	ISO 1133
Temperature	260 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11000 / 7000	MPa	ISO 527
Stress at Break	140 / 80	MPa	ISO 527
Strain at Break	2.5 / 3.4	%	ISO 527
Impact Strength (Charpy), +23°C	55 / 55	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	45 / -	kJ/m ²	ISO 179/1eU

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	203 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	218 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Thickness tested	1.6 / *	mm	-
Burning Behav. at thickness h	V-0 / *	class	UL 94
Thickness tested	0.8 / *	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Electric Strength	34.5 / -	kV/mm	IEC 60243-1
Comparative tracking index	400 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Humidity absorption	1.3 / *	%	Sim. to ISO 62
Density	1670 / -	kg/m ³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	134 / *	cm ³ /g	ISO 307, 1157, 1628

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Characteristics
Processing

Injection Molding

Additives

Lubricants, Release agent, Plasticizer

Delivery form

Pellets

Special Characteristics

Flame retardant, Light stabilized or stable to light

Injection Molding

PREPROCESSING

Max. Water content: 0.1 %

Drying temperature: 80 °C

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Drying time:

Dry air dryer 2-20 h (will depend on the initial moisture content)

PROCESSING

Melt temperature: 240 - 260 °C

Mold temperature: 80 - 100 °C
