

Durethan® AKV325H2.0 901510
PA66-GF25

Envalior

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8200 / 5000	MPa	ISO 527
Stress at Break	150 / 100	MPa	ISO 527
Strain at Break	3.8 / 10	%	ISO 527
Impact Strength (Charpy), +23°C	80 / 90	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65 / 65	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10 / 15	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	10 / 10	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	862 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	747 / -	N	ISO 6603-2
Puncture energy, +23°C	2.6 / -	J	ISO 6603-2
Puncture energy, -30°C	2.1 / -	J	ISO 6603-2
Flexural Modulus (23°C)	7200 / 4200	MPa	ISO 178
Flexural strength	240 / 140	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / 15	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	10 / 10	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	70 / 70	kJ/m²	ISO 180/1U
Ball Indentation Hardness	190 / 90	MPa	ISO 2039-1

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	261 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	236 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	240 / *	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Glow Wire (GWFI, Flammability Index)	600	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4.2 / -	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.8 / -	-	IEC 62631-2-1
Dissipation Factor, 100Hz	100 / -	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	180 / -	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / -	Ohm*m	IEC 62631-3-1
Electric Strength	32 / -	kV/mm	IEC 60243-1
Comparative tracking index	425 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	6.6 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1310 / -	kg/m³	ISO 1183
Bulk density	700	kg/m³	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

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Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 120	°C	-

Characteristics

Processing

Other Extrusion, Blow Molding

Chemical Resistance

Hydrolysis

Special Characteristics

Heat aging stabilized