

Durethan® AKV35CXH2.0 900876
PA66-GF30

Envalior

Injection Molding, 35% Glass Reinforced, Foam Applications, Heat Stabilized

ISO 1043 PA66-GF35

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11000 / 7000	MPa	ISO 527
Stress at Break	190 / 120	MPa	ISO 527
Strain at Break	2.8 / 5.5	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 85	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	60 / 55	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 15	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°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
Coeff. of Linear Therm. Expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5.9 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1410 / -	kg/m ³	ISO 1183

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

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 120	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

Heat aging stabilized

Delivery form

Pellets

Injection Molding
PREPROCESSING

Residual moisture content: 0.02 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 280 - 300 °C

Mold temperature: 80 - 120 °C