

Durethan® AKV35LTH2.0 904040
PA66-GF35

Envalior

Injection Molding, 35% Glass Reinforced, Heat Stabilized, Laser Transparent Black

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	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10800 / 7500	MPa	ISO 527
Stress at Break	192 / 119	MPa	ISO 527
Strain at Break	3 / 5.7	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 80	kJ/m ²	ISO 179/1eU

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	235 / *	°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	70 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Humidity absorption	2.1 / *	%	Sim. to ISO 62
Density	1400 / -	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	≤0.12	%	-
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: 0.03 - 0.12%

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