

Durethan® AKV15FN00 000000
 (PA66+PA6)-GF12 FR(40+30)

Envalior

Injection Molding, 12% Glass Reinforced, Heat Stabilized, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF12 FR(40+30)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6400 / 3700	MPa	ISO 527
Stress at Break	90 / 55	MPa	ISO 527
Strain at Break	3.1 / 7.1	%	ISO 527
Impact Strength (Charpy), +23°C	43 / 55	kJ/m ²	ISO 179/1eU

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	215 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	245 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5.5 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1280 / -	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

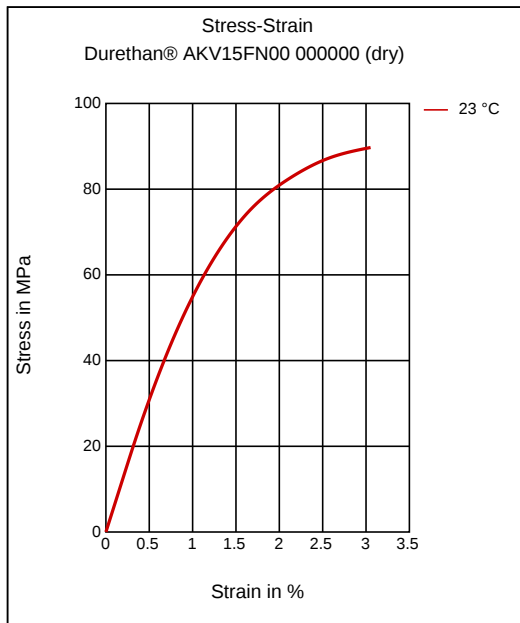
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	265 - 285	°C	-
Mold temperature	80 - 100	°C	-

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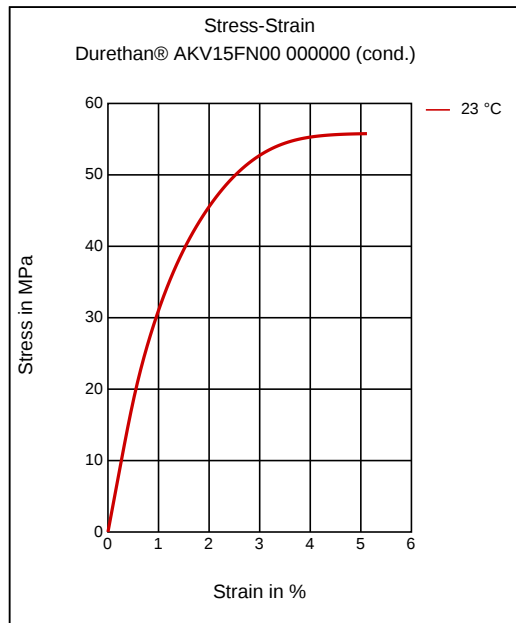
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Diagrams

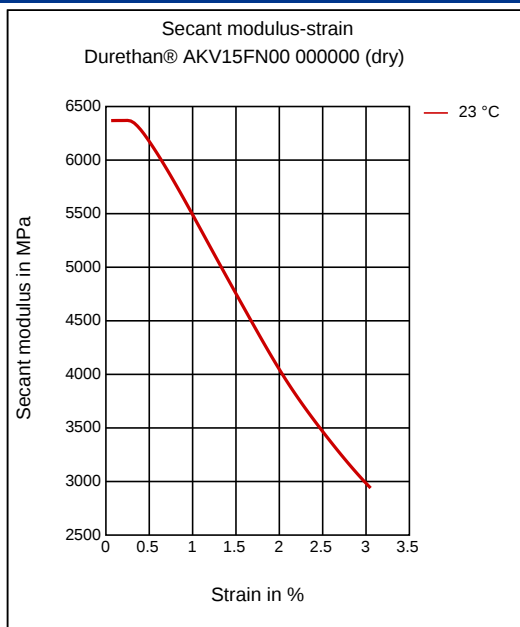
Stress-strain



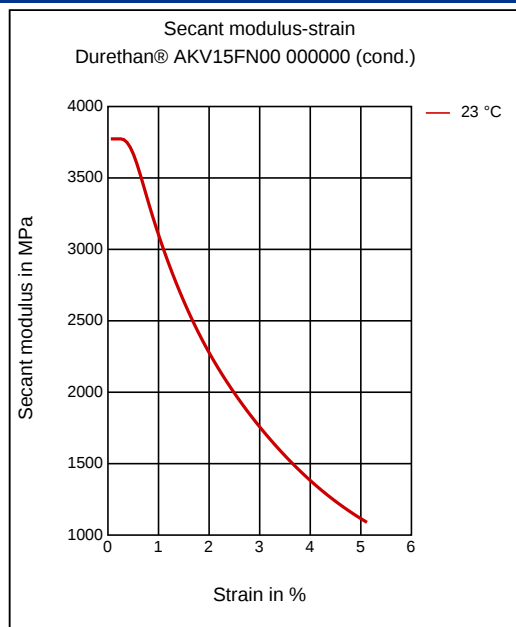
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

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Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 265 - 285 °C

Mold temperature: 80 - 100 °C
