

Durethan® AKV25FN04 000000
 (PA66+PA6)-GF25 FR(40)

Envalior

Injection Molding, 25% Glass Reinforced, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF25 FR(40)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9300 / 5700	MPa	ISO 527
Stress at Break	120 / 80	MPa	ISO 527
Strain at Break	3.3 / 6.5	%	ISO 527
Impact Strength (Charpy), +23°C	60 / 65	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	- / 13	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m ²	ISO 179/1eA
Flexural Modulus (23°C)	8900 / 5700	MPa	ISO 178
Flexural strength	200 / 135	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / -	kJ/m ²	ISO 180/1A
Impact Strength (Izod), 23°C	50 / 60	kJ/m ²	ISO 180/1U

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)	224 / *	°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	80 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.5 / *	mm	-
Oxygen index	31 / *	%	ISO 4589-1/-2
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.4	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	0.75	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	1.5	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.9 / 7.3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.4 / 3.8	-	IEC 62631-2-1
Dissipation Factor, 100Hz	200 / 935	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	180 / 595	E-4	IEC 62631-2-1
Volume Resistivity	>1E13 / 2.4E11	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 4.5E14	Ohm	IEC 62631-3-2
Electric Strength	40 / 36	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	4.8 / *	%	Sim. to ISO 62
Humidity absorption	1.6 / *	%	Sim. to ISO 62
Density	1380 / -	kg/m ³	ISO 1183

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

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Injection Molding, mold temperature

80

°C

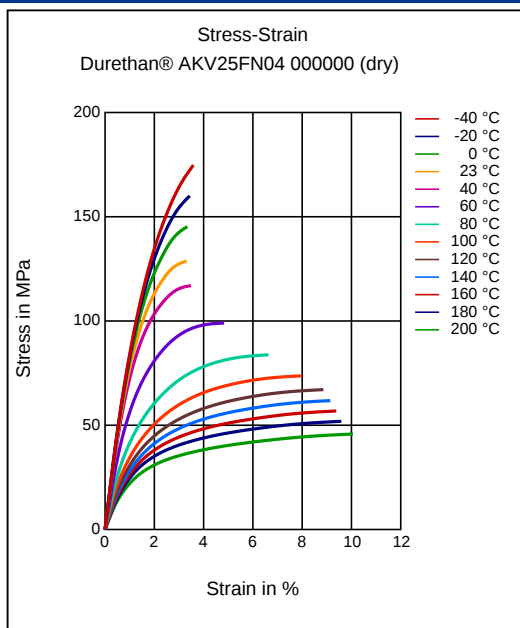
ISO 294

Processing Recommendation Injection Molding

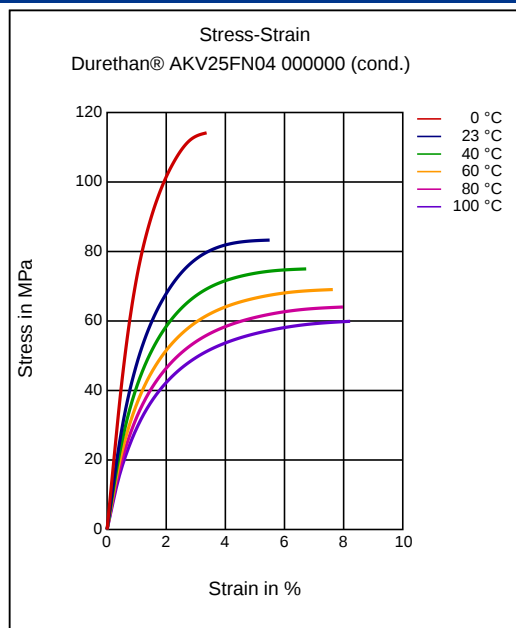
	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Melt temperature	265 - 285	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

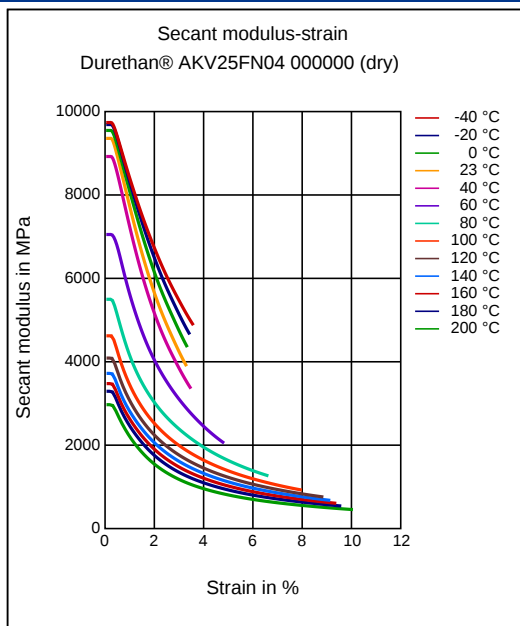
Stress-strain



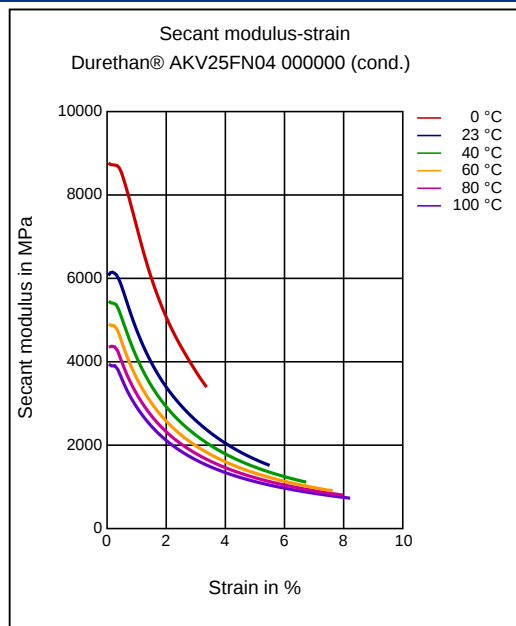
Stress-strain



Secant modulus-strain



Secant modulus-strain



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Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING

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