

Durethan® AKV15FN00

(PA66+PA6)—GF12 FR(40+72)

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

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.6 / *	%	ISO 294-4
Molding shrinkage (normal)	1 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	6400 / 3700	MPa	ISO 527-1/-2
Stress at break	90 / 55	MPa	ISO 527-1/-2
Strain at break	3.1 / 7.1	%	ISO 527-1/-2
Flexural modulus	6200 / 3300	MPa	ISO 178
Flexural strength	150 / 100	MPa	ISO 178
Charpy impact strength (+23°C)	43 / 55	kJ/m²	ISO 179/1eU
Izod notched impact strength (+23°C)	<10 / <10	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
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	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.4 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.4 / *	mm	IEC 60695-11-10
Burning Behav. at 0.75 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10

Property Data

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Thickness tested	0.75 / *	mm	IEC 60695-11-10
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	0.4 / –	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	0.8 / –	mm	IEC 60695-2-12

OTHER PROPERTIES	DRY / COND		
Water absorption	5.5 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1280 / –	kg/m³	ISO 1183

PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	265-285	°C	
Mold temperature	80-100	°C	