

# Durethan® AKV230H2.0

## PA66-I-GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized, Improved Impact

<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
<b>RHEOLOGICAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Molding shrinkage (parallel)	0.5 / *	%	ISO 294-4
Molding shrinkage (normal)	0.85 / *	%	ISO 294-4
<b>MECHANICAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Tensile modulus	8000 / 5100	MPa	ISO 527-1/-2
Stress at break	130 / 85	MPa	ISO 527-1/-2
Strain at break	4 / 6.5	%	ISO 527-1/-2
Flexural modulus	7000 / 4600	MPa	ISO 178
Flexural strength	200 / 135	MPa	ISO 178
Charpy impact strength (+23°C)	75 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (-30°C)	85 / 85	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	20 / 28	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (-30°C)	15 / 15	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	20 / 28	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Melting temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3
<b>OTHER PROPERTIES</b>			
	<i>DRY / COND</i>		
Density	1290 / -	kg/m <sup>3</sup>	ISO 1183
<b>PROCESSING RECOMMENDATIONS</b>			
	<i>VALUE</i>		
Drying temperature dry air dryer	80	°C	

## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Drying time dry air dryer	2–6	h	
Residual moisture content	0.03–0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	280–300	°C	
Mold temperature	80–120	°C	