

Durethan® AKV30GHR DUS023

PA66–GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized, Hydrolysis resistant,
 Improved flow, Excellent Surface Properties

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.64 / *	%	ISO 294–4
Molding shrinkage (normal)	0.82 / *	%	ISO 294–4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	8500 / 5600	MPa	ISO 527–1/–2
Stress at break	135 / 90	MPa	ISO 527–1/–2
Strain at break	3.2 / 6.5	%	ISO 527–1/–2
Flexural modulus	8000 / 5600	MPa	ISO 178
Flexural strength	215 / 150	MPa	ISO 178
Charpy impact strength (+23°C)	70 / 65	kJ/m ²	ISO 179/1eU
Charpy impact strength (–30°C)	55 / –	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / <10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (–30°C)	<10 / <10	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / <10	kJ/m ²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	259 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	200 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	245 / *	°C	ISO 75–1/–2
Coeff. of linear therm. expansion (parallel)	0.3 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	0.9 / *	E–4/°C	ISO 11359–1/–2

OTHER PROPERTIES

DRY / COND

Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Density	1340 / –	kg/m ³	ISO 1183
<i>PROCESSING RECOMMENDATIONS</i>			
	<i>VALUE</i>		
Drying temperature dry air dryer	80	°C	
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	