

Durethan® AKV35CXH2.0

PA66–GF35

35% Glass Reinforced, Injection Molding, Foam Applications, Heat Stabilized

<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
<i>RHEOLOGICAL PROPERTIES</i>			
	<i>DRY / COND</i>		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294–4
Molding shrinkage (normal)	0.9 / *	%	ISO 294–4
<i>MECHANICAL PROPERTIES</i>			
	<i>DRY / COND</i>		
Tensile modulus	11000 / 7000	MPa	ISO 527–1/–2
Stress at break	190 / 120	MPa	ISO 527–1/–2
Strain at break	2.8 / 5.5	%	ISO 527–1/–2
Flexural modulus	10500 / 6800	MPa	ISO 178
Flexural strength	290 / 200	MPa	ISO 178
Charpy impact strength (+23°C)	70 / 85	kJ/m ²	ISO 179/1eU
Charpy impact strength (–30°C)	60 / 55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 15	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 / 15	kJ/m ²	ISO 180/1A
<i>THERMAL PROPERTIES</i>			
	<i>DRY / COND</i>		
Melting temperature (10°C/min)	260 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	240 / *	°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)	0.2 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	1 / *	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>
Water absorption	5.9 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1410 / –	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	0.02–0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	280–300	°C	
Mold temperature	80–120	°C	