

Durethan® AKV35LTH3.0

PA66–GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized, Laser Transparent Black

<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
RHEOLOGICAL PROPERTIES			
	<i>DRY / COND</i>		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294–4
Molding shrinkage (normal)	0.9 / *	%	ISO 294–4
MECHANICAL PROPERTIES			
	<i>DRY / COND</i>		
Tensile modulus	11000 / 7500	MPa	ISO 527–1/–2
Stress at break	195 / 125	MPa	ISO 527–1/–2
Strain at break	3 / 5.5	%	ISO 527–1/–2
Flexural modulus	10000 / 7800	MPa	ISO 178
Flexural strength	295 / 214	MPa	ISO 178
Charpy impact strength (+23°C)	65 / 80	kJ/m ²	ISO 179/1eU
THERMAL PROPERTIES			
	<i>DRY / COND</i>		
Melting temperature (10°C/min)	260 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	230 / *	°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)	0.7 / *	E–4/°C	ISO 11359–1/–2
OTHER PROPERTIES			
	<i>DRY / COND</i>		
Density	1400 / –	kg/m ³	ISO 1183
PROCESSING RECOMMENDATIONS			
	<i>VALUE</i>		
Drying temperature dry air dryer	80	°C	

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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	