

# Durethan<sup>®</sup> DP2325H3.0 DUS031

## PA66–I

Injection Molding, Unreinforced, Heat Stabilized, Improved flow, 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)	1.9 / *	%	ISO 294–4
Molding shrinkage (normal)	1.7 / *	%	ISO 294–4
<b>MECHANICAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Tensile modulus	1850 / 650	MPa	ISO 527–1/–2
Nominal strain at break	>50 / –	%	ISO 527–1/–2
Yield stress	48 / 30	MPa	ISO 527–1/–2
Yield strain	15 / 35	%	ISO 527–1/–2
Flexural modulus	1800 / 700	MPa	ISO 178
Flexural strength	70 / 30	MPa	ISO 178
Charpy impact strength (+23°C)	N / N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (–30°C)	N / N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	80 / 100	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (–30°C)	20 / 20	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	75 / 100	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
Temp. of deflection under load (1.80 MPa)	60 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	140 / *	°C	ISO 75–1/–2
Coeff. of linear therm. expansion (parallel)	1.5 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	1.3 / *	E–4/°C	ISO 11359–1/–2

## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
<b><i>OTHER PROPERTIES</i></b>			
	<b><i>DRY / COND</i></b>		
Water absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1070 / –	kg/m <sup>3</sup>	ISO 1183
<b><i>PROCESSING RECOMMENDATIONS</i></b>			
	<b><i>VALUE</i></b>		
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)	270–290	°C	
Mold temperature	80–90	°C	
admissible residence time at Tmax	<10	min	