

# Durethan<sup>®</sup> DPAKV50HRH2.0

## PA66–GF50

50% Glass Reinforced, Injection Molding, Heat Stabilized, Hydrolysis resistant

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Molding shrinkage (parallel)	0.35 / *	%	ISO 294–4
Molding shrinkage (normal)	0.9 / *	%	ISO 294–4
<b>MECHANICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Tensile modulus	15800 / 10500	MPa	ISO 527–1/–2
Stress at break	225 / 160	MPa	ISO 527–1/–2
Strain at break	2.7 / 4.5	%	ISO 527–1/–2
Flexural modulus	15500 / 11000	MPa	ISO 178
Flexural strength	355 / 260	MPa	ISO 178
Charpy impact strength (+23°C)	100 / 95	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (–30°C)	100 / 100	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	15 / 20	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (–30°C)	12 / 13	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	15 / 20	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Melting temperature (10°C/min)	261 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	245 / *	°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
<b>OTHER PROPERTIES</b>			
	<b>DRY / COND</b>		

## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Water absorption	4.6 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1570 / –	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)	280–300	°C	
Mold temperature	80–120	°C	