

**Durethan® AC30 000000 DUS027**  
**PA66-I**

Envalior

Injection Molding, Unreinforced, Heat Stabilized, Improved Impact

ISO 1043 PA66-I

Rheological properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	27 / *	cm³/10min	ISO 1133
Temperature	270 / *	°C	-
Load	2.16 / *	kg	-
Molding shrinkage, parallel	1.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	3000 / 1100	MPa	ISO 527
Yield stress	70 / 40	MPa	ISO 527
Yield strain	6.5 / 25	%	ISO 527
Nominal strain at break	20 / >50	%	ISO 527
Impact Strength (Charpy), +23°C	no break / no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break / no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 25	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting Temperature (10°C/min)	261 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	70 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	195 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	80 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	110 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Other Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Density	1110 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

**Characteristics**
**Processing**

Injection Molding

**Additives**

Release agent

**Delivery form**

Pellets

**Special Characteristics**

Impact modified, Heat aging stabilized

**Injection Molding**
**PREPROCESSING**

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

#### PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

admissible residence time at Tmax ≤ 10 min

Mold temperature: 80 - 90 °C

#### Disclaimer

##### Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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