Durethan® ACF30XH2.0EF 901510

PA66-(GF+CF)30 Envalior

Injection Molding, 30% Mineral Reinforced, Heat Stabilized, Electrical Conductive, Improved flow

ISO 1043 PA66-(GF+CF)30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	12000 / 7400	MPa	ISO 527
Stress at Break	170 / 110	MPa	ISO 527
Strain at Break	2.5 / 4.5	%	ISO 527
Impact Strength (Charpy), +23°C	60 / 65	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	60 / 55	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 15	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	840 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	700 / -	N	ISO 6603-2
Puncture energy, +23°C	3.1 / -	J	ISO 6603-2
Puncture energy, -30°C	2.3 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	261 / *	°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	10 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Volume Resistivity	1000 / -	Ohm*m	IEC 62631-3-1

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5 / *	%	Sim. to ISO 62
Humidity absorption	1.7 / *	%	Sim. to ISO 62
Density	1300 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°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	≤0.07	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 120	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Electrically Conductive, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING
Residual moisture content: 0.03 - 0.07%
Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING
Melt temperature (Tmin - Tmax): 280 - 300 °C

Mold temperature: 80 - 120 °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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