

Durethan® AKV15FN00 000000
 (PA66+PA6)-GF12 FR(40+30)

Envalior

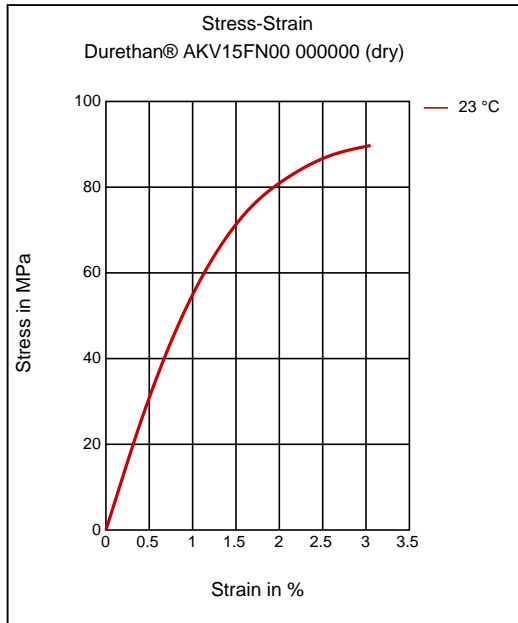
Injection Molding, 12% Glass Reinforced, Heat Stabilized, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF12 FR(40+30)

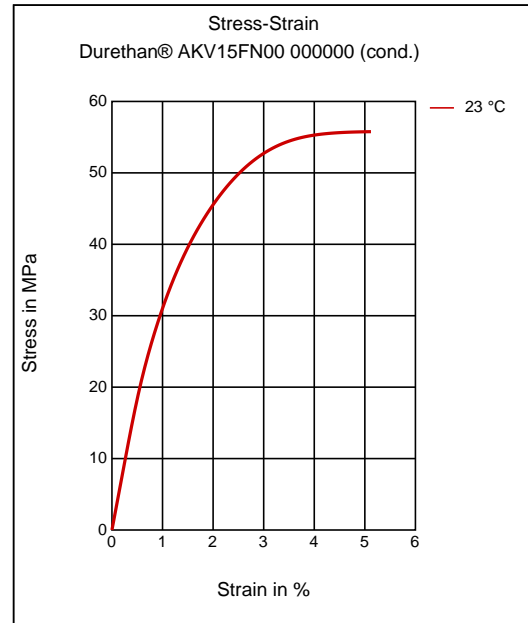
Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577
Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6400 / 3700	MPa	ISO 527
Stress at Break	90 / 55	MPa	ISO 527
Strain at Break	3.1 / 7.1	%	ISO 527
Impact Strength (Charpy), +23°C	43 / 55	kJ/m ²	ISO 179/1eU
Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	215 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	245 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5.5 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1280 / -	kg/m ³	ISO 1183
Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°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	265 - 285	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

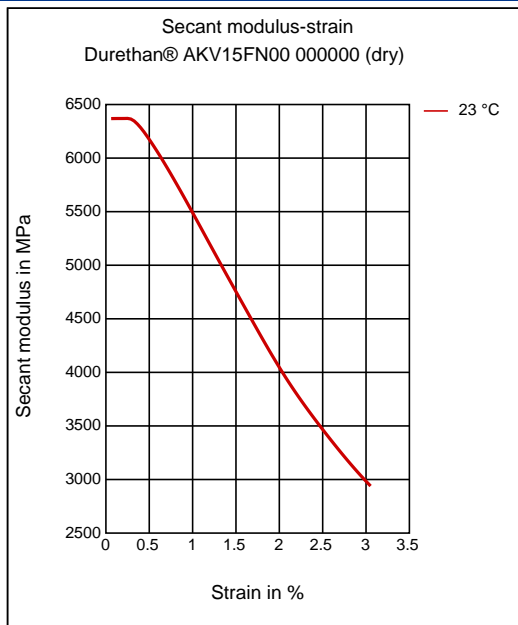
Stress-strain



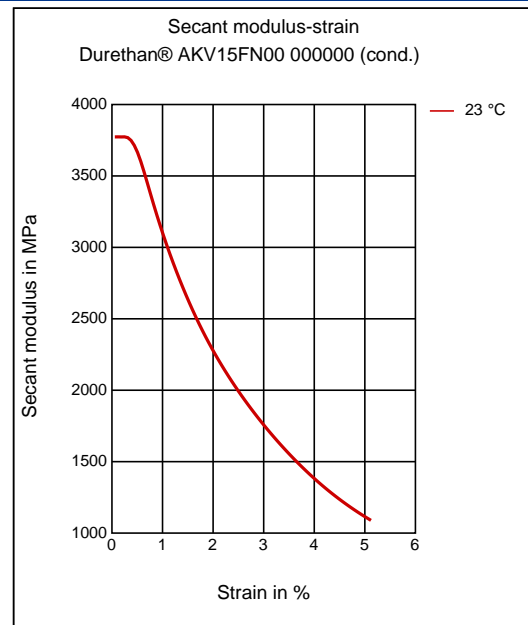
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

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): 265 - 285 °C

Mold temperature: 80 - 100 °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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