

**Durethan® AKV230H2.0 901510**  
**PA66-I-GF30**

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA66-I-GF30

Rheological properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	8000 / 5100	MPa	ISO 527
Stress at Break	130 / 85	MPa	ISO 527
Strain at Break	4 / 6.5	%	ISO 527
Impact Strength (Charpy), +23°C	75 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Impact Strength (Charpy), -30°C	85 / 85	kJ/m <sup>2</sup>	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 28	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	15 / 15	kJ/m <sup>2</sup>	ISO 179/1eA
Puncture - maximum force, +23°C	1200 / 1450	N	ISO 6603-2
Puncture - maximum force, -30°C	950 / 700	N	ISO 6603-2
Puncture energy, +23°C	7 / 10	J	ISO 6603-2
Puncture energy, -30°C	4 / 2.5	J	ISO 6603-2
Flexural Modulus (23°C)	7000 / 4600	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	20 / 28	kJ/m <sup>2</sup>	ISO 180/1A
Notched Impact Strength (Izod)	15 / 15	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	65 / 70	kJ/m <sup>2</sup>	ISO 180/1U

Thermal Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting Temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3

Other Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Density	1290 / -	kg/m <sup>3</sup>	ISO 1183

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
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	≤0.12	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 120	°C	-

**Characteristics**
**Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

Impact modified, Heat aging stabilized

**Features**

Thermal Stability

**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): 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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