

Durethan® AKV25FN04 000000
 (PA66+PA6)-GF25 FR(40)

Envalior

Injection Molding, 25% Glass Reinforced, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF25 FR(40)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9300 / 5700	MPa	ISO 527
Stress at Break	120 / 80	MPa	ISO 527
Strain at Break	3.3 / 6.5	%	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	- / 13	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	8900 / 5700	MPa	ISO 178
Flexural strength	200 / 135	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / -	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	50 / 60	kJ/m²	ISO 180/1U

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	224 / *	°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	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.5 / *	mm	-
Oxygen index	31 / *	%	ISO 4589-1/-2
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.4	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	0.75	mm	-
Glow Wire (GWFI, Flammability Index)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	1.5	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.9 / 7.3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.4 / 3.8	-	IEC 62631-2-1
Dissipation Factor, 100Hz	200 / 935	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	180 / 595	E-4	IEC 62631-2-1
Volume Resistivity	>1E13 / 2.4E11	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 4.5E14	Ohm	IEC 62631-3-2
Electric Strength	40 / 36	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	4.8 / *	%	Sim. to ISO 62
Humidity absorption	1.6 / *	%	Sim. to ISO 62
Density	1380 / -	kg/m³	ISO 1183

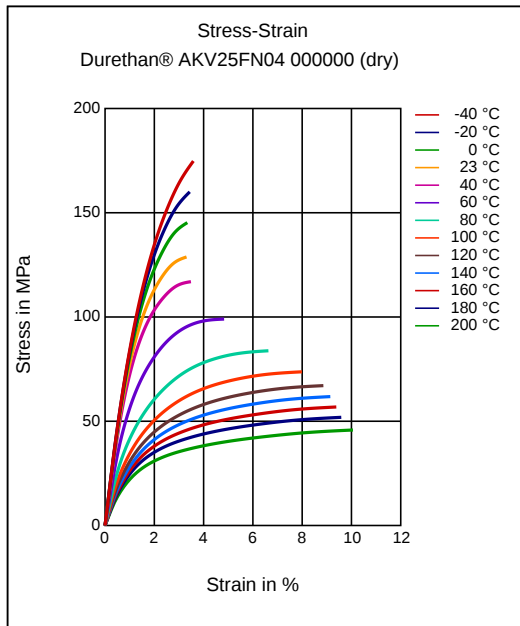
Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°C	ISO 294

Injection Molding, mold temperature 80 °C ISO 294

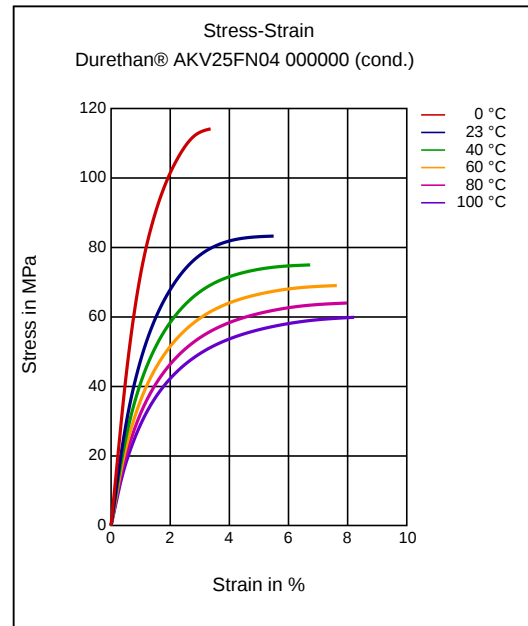
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Melt temperature	265 - 285	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

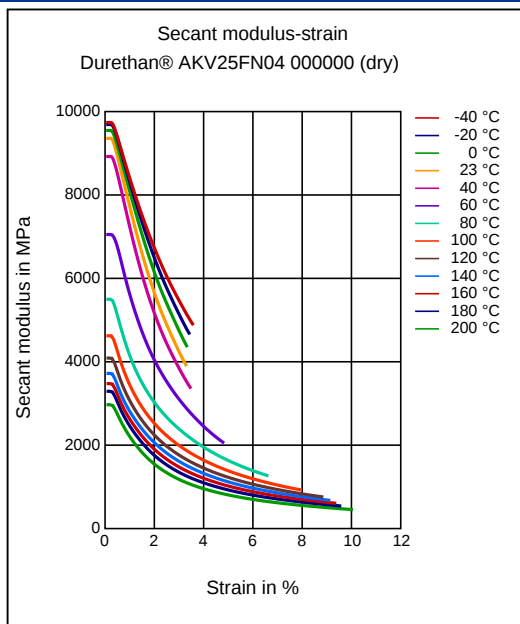
Stress-strain



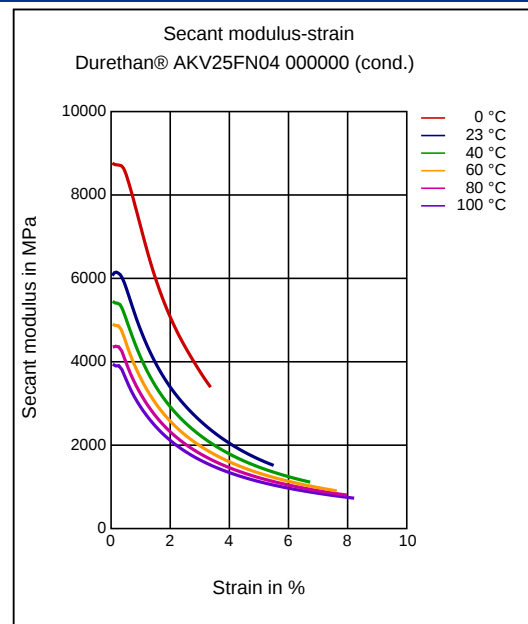
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING

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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