

Durethan® AKV30FN22 000000
PA66-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Flame Retardant (halogen free)

ISO 1043 PA66-GF30 FR(40+30)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	17 / *	cm³/10min	ISO 1133
Temperature	270 / *	°C	-
Load	2.16 / *	kg	-
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6000 / 3900	MPa	ISO 527
Stress at Break	85 / 56	MPa	ISO 527
Strain at Break	3.5 / 13.2	%	ISO 527
Impact Strength (Charpy), +23°C	35 / 60	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 10	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	263 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	200 / *	°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	40 / *	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-2 / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Electric Strength	30 / -	kV/mm	IEC 60243-1
Comparative tracking index	525 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1400 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	127 / *	cm³/g	ISO 307, 1157, 1628

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°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	260 - 270	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, Halogen-free

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): 260 - 270 °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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