Durethan® AM430H2.0 901510

PA66-MX30 Envalior

Injection Molding, 30% Mineral Reinforced, Heat Stabilized, Low Warpage

ISO 1043 PA66-MX30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.0 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	4800 / 2000	MPa	ISO 527
Stress at Break	80 / 40	MPa	ISO 527
Strain at Break	4 / 50	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 120	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	60 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 10	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA

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)	90 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	60 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1390 / -	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	≤0.12	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 120	°C	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat aging stabilized

Delivery form
Pellets

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
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