

Durethan® DP2325H3.0 000000 DUS031
PA66-I

Envalior

Injection Molding, Unreinforced, Heat Stabilized, Improved flow, Improved Impact

ISO 1043 PA66-I

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	1850 / 650	MPa	ISO 527
Yield stress	48 / 30	MPa	ISO 527
Yield strain	15 / 35	%	ISO 527
Nominal strain at break	>50 / -	%	ISO 527
Impact Strength (Charpy), +23°C	no break / no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break / no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	80 / 100	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	20 / 20	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	5430 / 4500	N	ISO 6603-2
Puncture - maximum force, -30°C	6150 / 6100	N	ISO 6603-2
Puncture energy, +23°C	44 / 37.5	J	ISO 6603-2
Puncture energy, -30°C	43.4 / 40.7	J	ISO 6603-2

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)	60 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	140 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	150 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	130 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1070 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°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	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

Impact modified, 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): 270 - 290 °C

admissible residence time at Tmax <=10 min

Mold temperature: 80 - 90 °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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