

**Durethan® DPAKV30HREF 901510**  
**PA66-GF30**

Envalior

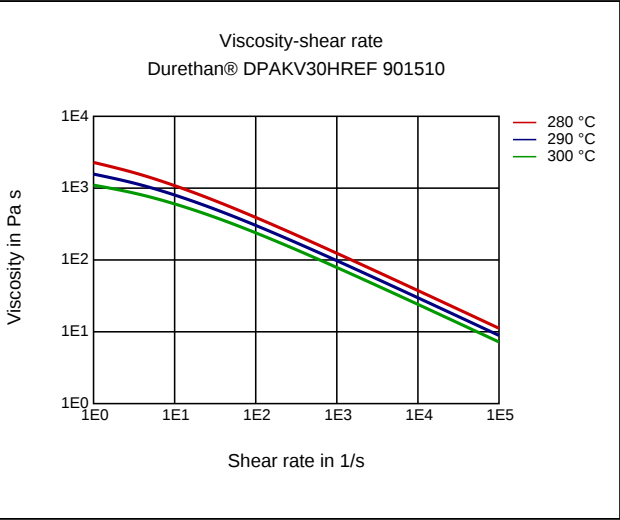
Injection Molding, 30% Glass Reinforced, Heat Stabilized, Hydrolysis resistant, Improved flow

ISO 1043 PA66-GF30

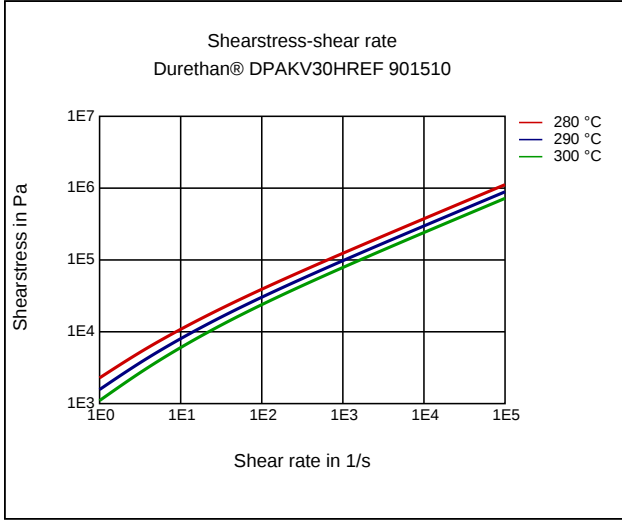
| Rheological properties                      | dry / cond  | Unit              | Test Standard   |
|---------------------------------------------|-------------|-------------------|-----------------|
| <b>ISO Data</b>                             |             |                   |                 |
| Molding shrinkage, parallel                 | 0.4 / *     | %                 | 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                             | 8200 / 5000 | MPa               | ISO 527         |
| Stress at Break                             | 150 / 100   | MPa               | ISO 527         |
| Strain at Break                             | 3.6 / 8     | %                 | ISO 527         |
| Impact Strength (Charpy), +23°C             | 80 / 80     | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Impact Strength (Charpy), -30°C             | 70 / -      | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Notched Impact Strength (Charpy), +23°C     | 10 / -      | kJ/m <sup>2</sup> | ISO 179/1eA     |
| Puncture - maximum force, +23°C             | 774 / -     | N                 | ISO 6603-2      |
| Puncture - maximum force, -30°C             | 756 / -     | N                 | ISO 6603-2      |
| Puncture energy, +23°C                      | 2.7 / -     | J                 | ISO 6603-2      |
| Puncture energy, -30°C                      | 2.5 / -     | J                 | ISO 6603-2      |
| Thermal Properties                          | dry / cond  | Unit              | Test Standard   |
| <b>ISO Data</b>                             |             |                   |                 |
| Melting Temperature (10°C/min)              | 263 / *     | °C                | ISO 11357-1/-3  |
| Temp. of deflection under load (1.80 MPa)   | 240 / *     | °C                | ISO 75-1/-2     |
| Temp. of deflection under load (0.45 MPa)   | 250 / *     | °C                | ISO 75-1/-2     |
| Other Properties                            | dry / cond  | Unit              | Test Standard   |
| <b>ISO Data</b>                             |             |                   |                 |
| Density                                     | 1320 / -    | 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                | -               |

Diagrams

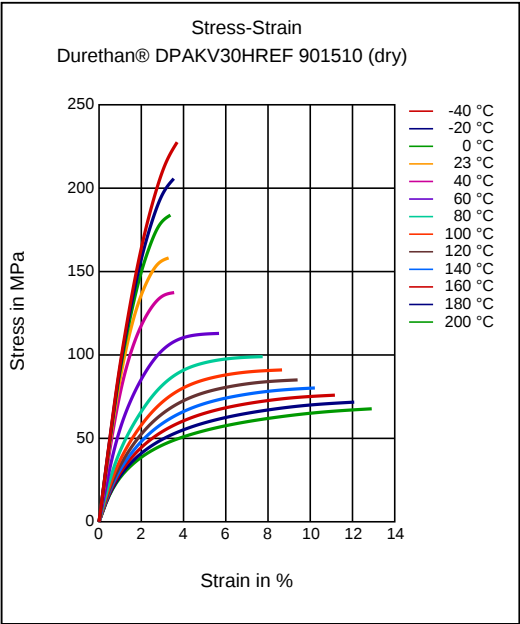
Viscosity-shear rate



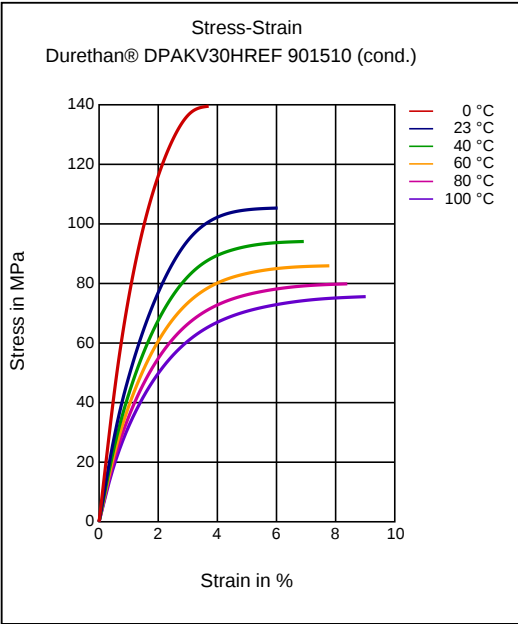
Shearstress-shear rate



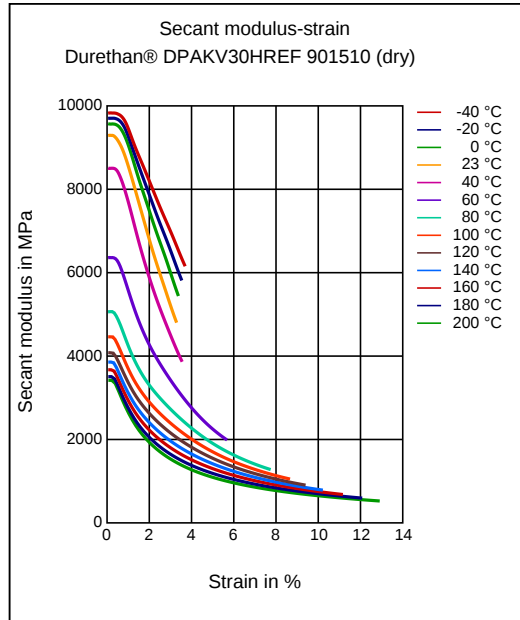
Stress-strain



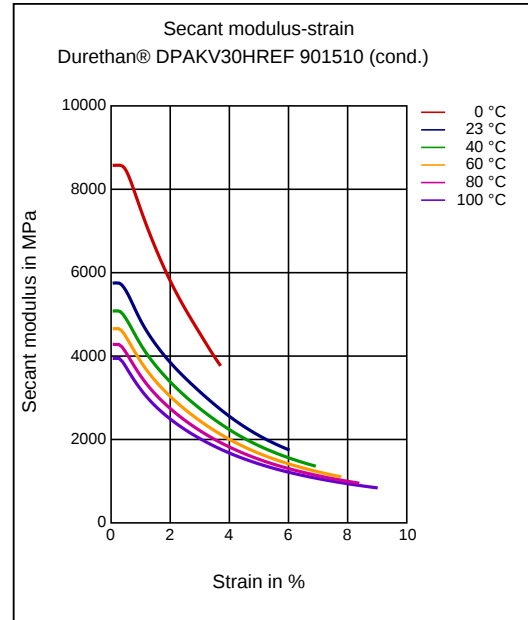
Stress-strain



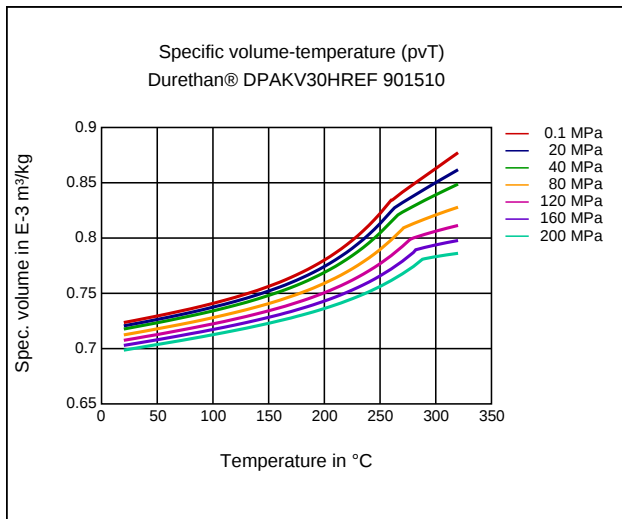
#### Secant modulus-strain



#### Secant modulus-strain



#### Specific volume-temperature (pvT)



#### Characteristics

##### Processing

Injection Molding

##### Delivery form

Pellets

##### Additives

Release agent

##### Special Characteristics

Heat aging stabilized

##### Chemical Resistance

Hydrolysis

#### 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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