

Durethan® AKV230H2.0 901510
PA66-I-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA66-I-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8000 / 5100	MPa	ISO 527
Stress at Break	130 / 85	MPa	ISO 527
Strain at Break	4 / 6.5	%	ISO 527
Impact Strength (Charpy), +23°C	75 / 80	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	85 / 85	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 28	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	15 / 15	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	1200 / 1450	N	ISO 6603-2
Puncture - maximum force, -30°C	950 / 700	N	ISO 6603-2
Puncture energy, +23°C	7 / 10	J	ISO 6603-2
Puncture energy, -30°C	4 / 2.5	J	ISO 6603-2
Flexural Modulus (23°C)	7000 / 4600	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	20 / 28	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	15 / 15	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	65 / 70	kJ/m²	ISO 180/1U

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1290 / -	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	Special Characteristics
Injection Molding	Impact modified, Heat aging stabilized

Delivery form	Features
Pellets	Thermal Stability

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