

Durethan® AKV25F30 000000
PA66-GF25 FR(17)

Envalior

Injection Molding, 25% Glass Reinforced, Heat Stabilized, Flame Retardant

ISO 1043 PA66-GF25 FR(17)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10500 / 8000	MPa	ISO 527
Stress at Break	150 / 100	MPa	ISO 527
Strain at Break	2.2 / 2.8	%	ISO 527
Impact Strength (Charpy), +23°C	50 / 50	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	40 / 40	kJ/m ²	ISO 179/1eU
Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	238 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	30 / *	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-0 / *	class	UL 94
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.0 / *	mm	-
Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	400 / -	-	IEC 60112
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	3.9 / *	%	Sim. to ISO 62
Humidity absorption	1.2 / *	%	Sim. to ISO 62
Density	1620 / -	kg/m ³	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 - 100	°C	-

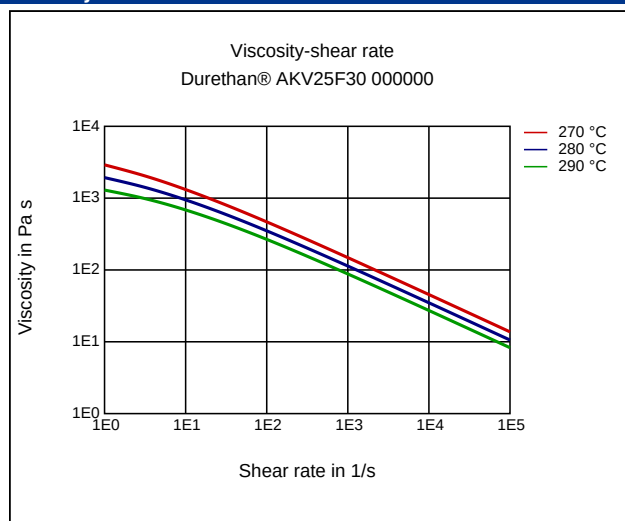
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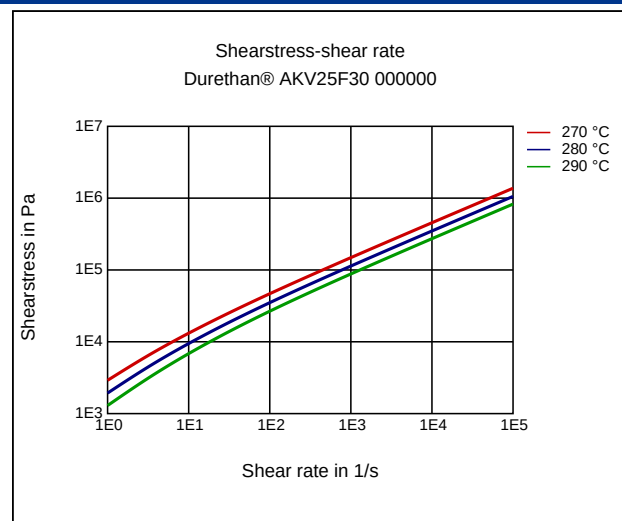
Envalior

Diagrams

Viscosity-shear rate



Shearstress-shear rate



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Flame retardant, Heat aging stabilized

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

Mold temperature: 80 - 100 °C