

Durethan® AKV30FN22 000000
PA66-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Flame Retardant (halogen free)

ISO 1043 PA66-GF30 FR(40+30)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	17 / *	cm ³ /10min	ISO 1133
Temperature	270 / *	°C	-
Load	2.16 / *	kg	-
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6000 / 3900	MPa	ISO 527
Stress at Break	85 / 56	MPa	ISO 527
Strain at Break	3.5 / 13.2	%	ISO 527
Impact Strength (Charpy), +23°C	35 / 60	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 10	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	263 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	200 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	40 / *	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-2 / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Electric Strength	30 / -	kV/mm	IEC 60243-1
Comparative tracking index	525 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1400 / -	kg/m ³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	127 / *	cm ³ /g	ISO 307, 1157, 1628

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°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	≤0.07	%	-
Melt temperature	260 - 270	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

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Processing

Injection Molding

Special Characteristics

Flame retardant, Halogen-free

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 260 - 270 °C

Mold temperature: 80 - 100 °C