

Durethan® AKV30GHR 900116 DUS023
PA66-GF30

Envalior

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

ISO 1043 PA66-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8500 / 5600	MPa	ISO 527
Stress at Break	135 / 90	MPa	ISO 527
Strain at Break	3.2 / 6.5	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 65	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	55 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 10	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	800 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	650 / -	N	ISO 6603-2
Puncture energy, +23°C	2.5 / -	J	ISO 6603-2
Puncture energy, -30°C	2 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	259 / *	°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)	245 / *	°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	90 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1340 / -	kg/m ³	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

Injection Molding

Delivery form

Pellets

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