

Durethan® DP2325H3.0 000000 DUS031
PA66-I

Envalior

Injection Molding, Unreinforced, Heat Stabilized, Improved flow, Improved Impact

ISO 1043 PA66-I

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	1850 / 650	MPa	ISO 527
Yield stress	48 / 30	MPa	ISO 527
Yield strain	15 / 35	%	ISO 527
Nominal strain at break	>50 / -	%	ISO 527
Impact Strength (Charpy), +23°C	no break / no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break / no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	80 / 100	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	20 / 20	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	5430 / 4500	N	ISO 6603-2
Puncture - maximum force, -30°C	6150 / 6100	N	ISO 6603-2
Puncture energy, +23°C	44 / 37.5	J	ISO 6603-2
Puncture energy, -30°C	43.4 / 40.7	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	262 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	60 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	140 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	150 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	130 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1070 / -	kg/m³	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 - 90	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

Impact modified, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

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Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

admissible residence time at Tmax ≤ 10 min

Mold temperature: 80 - 90 °C
