

Durethan® DP2325H3.0 000000
PA66-I

Envalior

Injection Molding, Unreinforced, Heat Stabilized, Improved Impact

ISO 1043 PA66-I

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	2.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9 / *	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	1850 / 700	MPa	ISO 527
Yield stress	50 / 30	MPa	ISO 527
Yield strain	30 / 35	%	ISO 527
Nominal strain at break	50 / 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	90 / 100	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	25 / 20	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	4900 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	5400 / -	N	ISO 6603-2
Puncture energy, +23°C	60 / -	J	ISO 6603-2
Puncture energy, -30°C	70 / -	J	ISO 6603-2
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	263 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	65 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	130 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	130 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	130 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thicken.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Oxygen index	20 / *	%	ISO 4589-1/-2
Electrical Properties			
ISO Data			
Relative permittivity, 100Hz	3.5 / 7	-	IEC 62631-2-1
Relative permittivity, 1MHz	3 / 3.4	-	IEC 62631-2-1
Dissipation Factor, 100Hz	80 / 1500	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	150 / 750	E-4	IEC 62631-2-1
Volume Resistivity	>1E13 / >1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E14	Ohm	IEC 62631-3-2
Electric Strength	40 / 45	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112
Other Properties			
ISO Data			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1080 / -	kg/m³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-

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Melt temperature	270 - 290	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Impact modified, 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