

Durethan® AKV30XTS1

PA66—GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized

Print Date: 2024—09—17

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.37 / *	%	ISO 294—4
Molding shrinkage (normal)	1.02 / *	%	ISO 294—4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	9900 / 6000	MPa	ISO 527—1/—2
Stress at break	175 / 110	MPa	ISO 527—1/—2
Strain at break	3 / 5.5	%	ISO 527—1/—2
Flexural modulus	9000 / 5800	MPa	ISO 178
Flexural strength	270 / 180	MPa	ISO 178
Tensile modulus (200°C)	3540	MPa	ISO 527—1/—2
Charpy impact strength (+23°C)	65 / —	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	9 / —	kJ/m²	ISO 179/1eA
Charpy notched impact strength (—30°C)	8 / —	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	10 / —	kJ/m²	ISO 180/1A
THERMAL PROPERTIES	DRY / COND		
Melting temperature (10°C/min)	263 / *	°C	ISO 11357—1/—3
Temp. of deflection under load (1.80 MPa)	235 / *	°C	ISO 75—1/—2
Coeff. of linear therm. expansion (parallel)	0.25 / *	E—4/°C	ISO 11359—1/—2
Coeff. of linear therm. expansion (normal)	0.9 / *	E—4/°C	ISO 11359—1/—2
OTHER PROPERTIES	DRY / COND		
Density	1360 / —	kg/m³	ISO 1183

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PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	270-290	°C	
Mold temperature	80-120	°C	
admissible residence time at Tmax	<5	min	

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