

# Durethan® AKV50

## PA66–GF50

50% Glass Reinforced, Injection Molding

Print Date: 2024–08–24

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>MECHANICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Tensile modulus	15700 / 10700	MPa	ISO 527–1/–2
Stress at break	220 / 170	MPa	ISO 527–1/–2
Strain at break	2.5 / 4	%	ISO 527–1/–2
Flexural modulus	14000 / 10300	MPa	ISO 178
Flexural strength	370 / 250	MPa	ISO 178
Charpy impact strength (+23°C)	95 / 95	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (–30°C)	100 / 100	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	19 / 23	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (–30°C)	15 / 15	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	14 / 18	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Melting temperature (10°C/min)	263 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	250 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75–1/–2
<b>OTHER PROPERTIES</b>			
	<b>DRY / COND</b>		
Water absorption	4 / *	%	Sim. to ISO 62
Humidity absorption	1.4 / *	%	Sim. to ISO 62
Density	1570 / –	kg/m <sup>3</sup>	ISO 1183
<b>MATERIAL SPECIFIC PROPERTIES</b>			
	<b>DRY / COND</b>		
Viscosity number	146 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

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## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
<b>PROCESSING RECOMMENDATIONS</b>			
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)	280-300	°C	
Mold temperature	80-120	°C	

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