

Durethan® AKV 30 G HR DUS023 900116

Polyamide 66

LANXESS GmbH

Message:

PA 66, 30 % glass fibers, injection molding, improved flowability, hydrolysis stabilized, improved surface finish, GIT/WIT

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Additive		Hydrolysis Resistant		
Features		Good Flow		
		Good Surface Finish		
		Hydrolysis Resistant		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.34	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 290°C, 2.00 mm ¹	0.82	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.040	--	%	
Flow : 290°C, 2.00 mm ³	0.64	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.050	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	8500	5600	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	135	90.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.2	6.5	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	8000	5600	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain,23°C	210	130	MPa	
23°C ⁶	215	150	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	3.8	5.8	%	ISO 178/A
ISO Shortname	PA 66, GHRW, 14-080, GF30	--		ISO 1874
Residual Moisture Content	0.030 to 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	< 10	< 10	kJ/m ²	
23°C	< 10	< 10	kJ/m ²	

Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	55	--	kJ/m ²	
23°C	70	65	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
-30°C	< 10	< 10	kJ/m ²	
23°C	< 10	< 10	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	45	--	kJ/m ²	
23°C	60	60	kJ/m ²	
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	2.00	--	J	
23°C	2.50	--	J	
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	650	--	N	
23°C	800	--	N	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	245	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	200	--	°C	ISO 75-2/A
8.0 MPa, Unannealed	75.0	--	°C	ISO 75-2/C
Melting Temperature ⁸	259	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	3.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	9.0E-5	--	cm/cm/°C	
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 to 6.0		hr	
Processing (Melt) Temp	280 to 300		°C	
Mold Temperature	80.0 to 120		°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 bar			
4.	60x60x2mm			
5.	2.0 mm/min			
6.	2.0 mm/min			

7.	2 mm/min
8.	10°C/min

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