

Durethan® DP 2802/30 000000

Polyamide 66

LANXESS Corporation

Message:

PA 66, 30 % glass fibers, injection molding, halogen free flame retardant

General Information				
UL YellowCard		E245249-473613		
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Additive		Flame retardancy		
Features		Halogen-free		
		Flame retardancy		
Agency Ratings		EC 1907/2006 (REACH)		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA GF FR (30)		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.40	--	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (270°C/2.16 kg)	17.0	--	cm³/10min	ISO 1133
Molding Shrinkage				ISO 2577
Vertical flow direction: 280°C, 2.00mm ¹	0.90	--	%	ISO 2577
Vertical flow direction: 120°C, 4 hours, 2.00mm ²	0.20	--	%	ISO 2577
Flow direction: 280°C, 2.00mm ³	0.80	--	%	ISO 2577
Flow direction: 120°C, 4 hours, 2.00mm ⁴	0.20	--	%	ISO 2577
Viscosity Number	127	--	cm³/g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness	200	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	6000	3900	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	85.0	56.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.5	13	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	6700	3700	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% strain, 23°C	165	80.0	MPa	ISO 178/A
23°C ⁶	170	90.0	MPa	ISO 178/A
Flexural Strain at Flexural Strength ⁷ (23°C)	4.3	6.5	%	ISO 178/A

ISO Shortname	PA 66, GF, 14-060, GF30	--		ISO 1874
Residual Moisture Content	0.030 - 0.070		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	< 10	< 10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	35	60	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	< 10	< 10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	30	50	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	250	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Vicat Softening Temperature				
--	245	--	°C	ISO 306/B50
--	> 230	--	°C	ISO 306/B120
Ball Pressure Test (255°C)	Pass	--		IEC 60695-10-2
Melting Temperature ⁸	263	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	4.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	8.0E-5	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (23°C, 1.00 mm)	33	--	kV/mm	IEC 60243-1
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.750 mm	V-2	--		UL 94
1.50 mm	V-2	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	960	--	°C	IEC 60695-2-12
1.50 mm	960	--	°C	IEC 60695-2-12
3.00 mm	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (0.750 mm)	775	--	°C	IEC 60695-2-13
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 - 6.0		hr	

Processing (Melt) Temp	260 - 270	°C
Mold Temperature	80.0 - 100	°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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