

Durethan® AKV 25 F30 000000

Polyamide 66

LANXESS GmbH

Message:

PA 66, 25 % glass fibers, injection molding, flame retardant

General Information				
UL YellowCard		E245249-100668706	E245249-101458614	
Filler / Reinforcement		Glass fiber reinforced material, 25% filler by weight		
Additive		Flame retardancy		
Features		Flame retardancy		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA GF FR(17)		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.60	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Vertical flow direction: 290°C, 2.00mm ¹	0.70	--	%	ISO 2577
Vertical flow direction: 120°C, 4 hours, 2.00mm ²	0.30	--	%	ISO 2577
Flow direction: 290°C, 2.00mm ³	0.40	--	%	ISO 2577
Flow direction: 120°C, 4 hours, 2.00mm ⁴	0.10	--	%	ISO 2577
Water Absorption				ISO 62
Saturated, 23°C	3.9	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10500	8000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	150	100	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.2	2.8	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	10000	7300	MPa	ISO 178/A
Flexural Stress ⁶ (23°C)	220	160	MPa	ISO 178/A
Flexural Strain at Flexural Strength ⁷ (23°C)	2.5	3.5	%	ISO 178/A
ISO Shortname	PA 66,GFHR,14-100,GF25	--		ISO 1874
Residual Moisture Content	0.030 - 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	40	40	kJ/m ²	ISO 179/1eU

23°C	50	50	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	< 10	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	40	40	kJ/m ²	ISO 180/1U
23°C	45	45	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	> 240	--	°C	ISO 75-2/B
1.8 MPa, not annealed	238	--	°C	ISO 75-2/A
Vicat Softening Temperature	240	--	°C	ISO 306/B120
Melting Temperature ⁸	260	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	3.0E-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
Comparative Tracking Index (Solution A)	400	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.400 mm	V-0	--		UL 94
0.750 mm	V-0	--		UL 94
	V-0			
1.00 mm	5VA	--		UL 94
	V-0			
3.00 mm	5VA	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.400 mm	960	--	°C	IEC 60695-2-12
0.800 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				IEC 60695-2-13
0.400 mm	875	--	°C	IEC 60695-2-13
0.800 mm	775	--	°C	IEC 60695-2-13
1.50 mm	775	--	°C	IEC 60695-2-13
3.00 mm	900	--	°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	270 - 290	°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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