

Durethan® DP 2325 H3.0 000000

Polyamide 66

LANXESS Asia/Pacific

Message:

PA 66, non-reinforced, injection molding, improved impact strength, heat-aging stabilized

General Information				
Additive		Heat Stabilizer		
Features		Good Impact Resistance		
		Heat Stabilized		
Agency Ratings		EC 1907/2006 (REACH)		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.08	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 280°C, 2.00 mm ¹	1.6	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.20	--	%	
Flow : 280°C, 2.00 mm ³	2.1	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.50	--	%	
Across Flow : 280°C, 3.00 mm ⁵	1.9	--	%	
Across Flow : 120°C, 4 hr, 3.00 mm ⁶	0.10	--	%	
Flow : 280°C, 3.00 mm ⁷	2.1	--	%	
Flow : 120°C, 4 hr, 3.00 mm ⁸	0.50	--	%	
Water Absorption				ISO 62
Saturation, 23°C	7.0	--	%	
Equilibrium, 23°C, 50% RH	2.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	1800	700	MPa	ISO 527-2/1
Tensile Stress				
Yield, 23°C	50.0	30.0	MPa	ISO 527-2/50
Break, 23°C	47.0	49.0	MPa	ISO 527-2/5
Tensile Strain				
Yield, 23°C	21	38	%	ISO 527-2/50
Break, 23°C	80	290	%	ISO 527-2/5

Nominal Tensile Strain at Break (23°C)	50	50	%	ISO 527-2/50
Flexural Modulus ⁹ (23°C)	1700	660	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain, 23°C	55.0	19.0	MPa	
23°C ¹⁰	70.0	27.0	MPa	
Flexural Strain at Flexural Strength ¹¹ (23°C)	7.2	8.7	%	ISO 178/A
Burning Behavior ¹² (> 1.00 mm)	25	--		ISO 3795
ISO Shortname	PA 66-HI, GHR, 14-020	--		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	20	20	kJ/m ²	
23°C	50	100	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	No Break		
23°C	No Break	No Break		
Notched Izod Impact Strength				ISO 180/1A
-30°C	25	20	kJ/m ²	
23°C	80	100	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	No Break	No Break		
23°C	No Break	No Break		
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	60.0	--	J	
23°C	50.0	--	J	
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	5400	--	N	
23°C	3900	--	N	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	110	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	60.0	--	°C	ISO 75-2/A
8.0 MPa, Unannealed	50.0	--	°C	ISO 75-2/C
Vicat Softening Temperature	> 200	--	°C	ISO 306/B50, ISO 306/B120
Melting Temperature ¹³	263	--	°C	ISO 11357-3

CLTE				ISO 11359-2
Flow : 23 to 55°C	1.3E-4	--	cm/cm/°C	
Transverse : 23 to 55°C	1.3E-4	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+14	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+19	1.0E+17	ohms·cm	IEC 60093
Electric Strength (23°C, 1.00 mm)	40	45	kV/mm	IEC 60243-1
Relative Permittivity				IEC 60250
23°C, 100 Hz	3.50	7.00		
23°C, 1 MHz	3.00	3.40		
Dissipation Factor				IEC 60250
23°C, 100 Hz	8.0E-3	0.15		
23°C, 1 MHz	0.015	0.075		
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	HB	--		
3.20 mm	HB	--		
Glow Wire Flammability Index (2.00 mm)	650	--	°C	IEC 60695-2-12
Oxygen Index ¹⁴	20	--	%	ISO 4589-2
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	270 to 290		°C	
Mold Temperature	80.0 to 100		°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 bar			
4.	60x60x2mm			
5.	150x105x3mm, 80°C MT, 500 bar			
6.	150x105x3mm			
7.	150x105x3mm, 80°C MT, 500 bar			
8.	150x105x3mm			
9.	2.0 mm/min			
10.	2.0 mm/min			
11.	2 mm/min			

12.	US-FMVSS302
13.	10°C/min
14.	Procedure A

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

