

Durethan® AKV 35 XTS1 901510

Polyamide 66

LANXESS GmbH

Message:

PA 66, 35% glass fibers, injection molding, heat-aging stabilized, notably high heat-aging stability

General Information				
Filler / Reinforcement		Glass Fiber,35% Filler by Weight		
Additive		Heat Stabilizer		
Features		Good Heat Aging Resistance		
		Heat Stabilized		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.41	--	g/cm ³	ISO 1183
Apparent Density	0.70	--	g/cm ³	ISO 60
Molding Shrinkage				ISO 2577
Across Flow : 280°C, 2.00 mm ¹	0.90	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.15	--	%	
Flow : 280°C, 2.00 mm ³	0.35	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.050	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10700	6800	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	185	105	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.2	5.0	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	10100	6200	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain,23°C	280	140	MPa	
23°C ⁶	280	180	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	3.5	5.0	%	ISO 178/A
ISO Shortname	PA 66, GHR, 14-110, GF35	--		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	15	kJ/m ²	

Charpy Unnotched Impact Strength (23°C)	75	85	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength				ISO 180/1A
-30°C	< 10	< 10	kJ/m ²	
23°C	10	15	kJ/m ²	
Unnotched Izod Impact Strength (23°C)	65	70	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	250	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	235	--	°C	ISO 75-2/A
Melting Temperature ⁸	261	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	9.5E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	2.0E-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	270 to 290		°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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