

Datasheet

Durethan AKV35CXH2.0 900876

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

ISO Shortname: ISO 16396-PA 66,GF35,GHR,S12-110

Property	Test Condition	Unit	Standard	guide value ¹	
				d.a.m.	cond.
Rheological properties					
C Molding shrinkage, parallel	60x60x2; 290 °C / MT 80 °C; 600 bar	%	ISO 294-4	0.3	
C Molding shrinkage, transverse	60x60x2; 290 °C / MT 80 °C; 600 bar	%	ISO 294-4	0.9	
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.05	
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1	
Mechanical properties (23 °C/50 % r. h.)					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	11000	7000
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	190	120
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	2.8	5.5
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	70	85
C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	60	55
C Charpy notched impact strength	23 °C	kJ/m²	ISO 179-1eA	<10	15
C Charpy notched impact strength	-30 °C	kJ/m²	ISO 179-1eA	<10	<10
Izod impact strength	23 °C	kJ/m²	ISO 180-1U	60	70
Izod impact strength	-30 °C	kJ/m²	ISO 180-1U	55	55
Izod notched impact strength	23 °C	kJ/m²	ISO 180-1A	10	15
Izod notched impact strength	-30 °C	kJ/m²	ISO 180-1A	<10	<10
Flexural modulus	2 mm/min	MPa	ISO 178-A	10500	6800
Flexural strength	2 mm/min	MPa	ISO 178-A	290	200
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	3.5	5
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	290	170
Thermal properties					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	260	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	240	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	250	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.2	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1	
Other properties (23 °C)					
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	5.9	
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	1.9	
C Density		kg/m³	ISO 1183	1405	
Bulk density		kg/m³	ISO 60	650	

Processing conditions for test specimens

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C Injection molding-Melt temperature		°C	ISO 294	290
C Injection molding-Mold temperature		°C	ISO 294	80
Processing recommendations				
Drying temperature dry air dryer		°C	-	80
Drying time dry air dryer		h	-	2-6
Residual moisture content		%	Acc. to Karl Fischer	0.02-0.07
Melt temperature (Tmin - Tmax)		°C	-	280-300
Mold temperature		°C	-	80-120

Notes

1 Typical properties: these are not to be construed as specifications

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

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