

Datasheet

Durethan DP2325H3.0 000000 DUS031

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

ISO Shortname: ISO 16396-PA 66-I,,GHR,S12-020

Property	Test Condition	Unit	Standard	guide value ¹ d.a.m. cond.	
Rheological properties					
C Molding shrinkage, parallel	60x60x2; 280 °C / MT 80 °C; 600 bar	%	ISO 294-4	1.9	
C Molding shrinkage, transverse	60x60x2; 280 °C / MT 80 °C; 600 bar	%	ISO 294-4	1.7	
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.4	
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.3	
Mechanical properties (23 °C/50 % r. h.)					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	1850	650
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	48	30
C Yield strain	50 mm/min	%	ISO 527-1,-2	15	35
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	60	
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	N	N
C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	N	N
C Charpy notched impact strength	23 °C	kJ/m²	ISO 179-1eA	80	100
C Charpy notched impact strength	-30 °C	kJ/m²	ISO 179-1eA	20	20
Izod impact strength	23 °C	kJ/m²	ISO 180-1U	N	N
Izod impact strength	-30 °C	kJ/m²	ISO 180-1U	N	N
Izod notched impact strength	23 °C	kJ/m²	ISO 180-1A	75	100
Izod notched impact strength	-30 °C	kJ/m²	ISO 180-1A	20	20
Flexural modulus	2 mm/min	MPa	ISO 178-A	1800	700
Flexural strength	2 mm/min	MPa	ISO 178-A	70	30
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	7	7
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	55	20
C Puncture maximum force	23 °C	N	ISO 6603-2	5425	4500
C Puncture maximum force	-30 °C	N	ISO 6603-2	6150	6100
C Puncture energy	23 °C	J	ISO 6603-2	44	37.5
C Puncture energy	-30 °C	J	ISO 6603-2	43.4	40.7
Thermal properties					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	262	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	60	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	140	
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	195	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.5	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.3	

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Property	Test Condition	Unit	Standard	guide value ¹ d.a.m. cond.
Other properties (23 °C)				
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	7
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	2
C Density		kg/m ³	ISO 1183	1075
Bulk density		kg/m ³	ISO 60	700
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	280
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	0.03-0.12
Melt temperature (Tmin - Tmax)		°C	-	270-290
admissible residence time at Tmax		min	-	<=10
Mold temperature		°C	-	80-90

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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Typical Properties

Property data is provided as general information only. Property values are approximate and are not part of the product specifications.

Flammability

Flammability results are based on small-scale laboratory tests for purposes of relative comparison and are not intended to reflect the hazards presented by this or any other material under actual fire conditions.

Health and Safety

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling Envalior products mentioned in this publication. Before working with these products, you must read and become familiar with the available information on their hazards, proper use, and handling. This cannot be overemphasized. Information is available in several forms, e.g., material safety data sheets (MSDS) and product labels. Consult your Envalior representative or contact the Product Safety and Regulatory Affairs Department. For materials that are not Envalior products, appropriate industrial hygiene and other safety precautions recommended by their manufacturer(s) must be followed.

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Color and Visual Effects

Type and quantity of pigments or additives used to obtain certain colors and special visual effects can affect mechanical properties.