

# Datasheet

## Durethan DP2325H3.0 000000

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

ISO Shortname: ISO 16396-PA 66-I,,GHR,S14-020

Property	Test Condition	Unit	Standard	guide value <sup>1</sup>	
				d.a.m.	cond.
<b>Rheological properties</b>					
Molding shrinkage, parallel	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 294-4	2.1	
Molding shrinkage, transverse	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 294-4	1.9	
Post- shrinkage, parallel	150x105x3; 120 °C; 4 h	%	acc. ISO 294-4	0.5	
Post- shrinkage, transverse	150x105x3; 120 °C; 4 h	%	acc. ISO 294-4	0.1	
C Molding shrinkage, parallel	60x60x2; 280 °C / MT 80 °C; 600 bar	%	ISO 294-4	2.1	
C Molding shrinkage, transverse	60x60x2; 280 °C / MT 80 °C; 600 bar	%	ISO 294-4	1.9	
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.4	
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.2	
<b>Mechanical properties (23 °C/50 % r. h.)</b>					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	1850	700
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	50	30
C Yield strain	50 mm/min	%	ISO 527-1,-2	30	35
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	50	50
C Charpy impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eU	N	N
C Charpy impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eU	N	N
C Charpy notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eA	90	100
C Charpy notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eA	25	20
Izod impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1U	N	N
Izod impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1U	N	N
Izod notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1A	85	100
Izod notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1A	25	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	8.7
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	4900	
C Puncture maximum force	-30 °C	N	ISO 6603-2	5400	
C Puncture energy	23 °C	J	ISO 6603-2	60	
C Puncture energy	-30 °C	J	ISO 6603-2	70	
Ball indentation hardness		N/mm <sup>2</sup>	ISO 2039-1	84	50
<b>Thermal properties</b>					

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Property	Test Condition	Unit	Standard	guide value <sup>1</sup>	
				d.a.m.	cond.
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	263	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	65	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	130	
C Temperature of deflection under load	8.00 MPa	°C	ISO 75-1,-2	50	
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	> 200	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	1.3	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	1.3	
C Burning behavior UL 94	1.5 mm	Class	UL 94	HB	
C Oxygen index	Method A	%	ISO 4589-2	20	
Glow wire test (GWFI)	2.0 mm	°C	IEC 60695-2-12	650	
Burning behavior US-FMVSS302	>=1.0 mm		ISO 3795	passed	
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	> 200	
<b>Electrical properties (23 °C/50 % r. h.)</b>					
C Relative permittivity	100 Hz	-	IEC 60250	3.5	7.0
C Relative permittivity	1 MHz	-	IEC 60250	3.0	3.4
C Dissipation factor	100 Hz	10 <sup>-4</sup>	IEC 60250	80	1500
C Dissipation factor	1 MHz	10 <sup>-4</sup>	IEC 60250	150	750
C Volume resistivity		Ohm·m	IEC 62631-3	1E17	1E15
C Surface resistivity		Ohm	IEC 62631-3	1E15	1E14
C Electric strength	1 mm	kV/mm	IEC 60243-1	40	45
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	600	
<b>Other properties (23 °C)</b>					
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	7.0	
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	2.0	
C Density		kg/m <sup>3</sup>	ISO 1183	1076	
Bulk density		kg/m <sup>3</sup>	ISO 60	600	
<b>Processing conditions for test specimens</b>					
C Injection molding-Melt temperature		°C	ISO 294	280	
C Injection molding-Mold temperature		°C	ISO 294	80	
<b>Processing recommendations</b>					
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	
Mold temperature		°C	-	80-100	

Notes

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### **Durethan DP2325H3.0 000000**

**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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#### Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

#### Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

#### Conditioning

Conditioning in accordance with ISO 1110 (70 °C; 62 % r.h.)

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