

Durethan® AKV15FN00 000000

(PA66+PA6)-GF12 FR(40+30)

Envalior

Product Texts

Injection Molding, 12% Glass Reinforced, Heat Stabilized, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF12 FR(40+30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	6400 / 3700	MPa	ISO 527
^[C] Stress at break	90 / 55	MPa	ISO 527
^[C] Strain at break	3.1 / 7.1	%	ISO 527
^[C] Charpy impact strength, +23°C	43 / 55	kJ/m ²	ISO 179/1eU

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	262 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	215 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	245 / *	°C	ISO 75-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	5.5 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1280 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	265 - 285	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

Flame retardant, Halogen-free, Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Other text information

Injection molding

PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 265 - 285 °C

Mold temperature: 80 - 100 °C