

Product Texts

Injection Molding, 25% Glass Reinforced, Heat Stabilized, Flame Retardant (halogen free)

ISO 1043 (PA66+PA6)-GF25 FR(40+30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	12 / *	cm ³ /10min	ISO 1133
Temperature	270 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	9600 / 5800	MPa	ISO 527
^[C] Stress at break	125 / 80	MPa	ISO 527
^[C] Strain at break	3 / 6	%	ISO 527
^[C] Charpy impact strength, +23°C	60 / 65	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	60 / 60	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	- / 10	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	225 / *	°C	ISO 75-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
^[C] Burning Behav. 5V at thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.5 / *	mm	-
^[C] Oxygen index	38 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
^[C] Electric strength	35 / -	kV/mm	IEC 60243-1
^[C] Comparative tracking index	600 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	4.6 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.5 / *	%	Sim. to ISO 62
^[C] Density	1390 / -	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

Characteristics

Durethan® AKV25FN00 000000

(PA66+PA6)-GF25 FR(40+30)

Envalior

Processing

Injection Molding

Special Characteristics

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

Delivery form

Pellets

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