

Durethan® AM 40 X H2.0 DUS041 901510

Polyamide 66

LANXESS GmbH

Message:

PA 66, 40 % glass fibers/mineral, injection molding, heat-aging stabilized, low tendency to warp

General Information				
Filler / Reinforcement		Glass\Mineral,40% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
		Low Warpage		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.46	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 290°C, 2.00 mm ¹	1.0	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.10	--	%	
Flow : 290°C, 2.00 mm ³	0.45	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.050	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10600	6500	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	150	85.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.7	5.5	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	9700	6000	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain,23°C	--	140	MPa	
23°C ⁶	240	150	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	3.0	5.0	%	ISO 178/A
ISO Shortname	PA 66, GHR, 14-120, (GF+MD) 40			ISO 1874
Residual Moisture Content	0.030 to 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	< 10	< 10	kJ/m ²	
23°C	< 10	< 10	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU

-30°C	50	45	kJ/m ²	
23°C	55	60	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
-30°C	10	< 10	kJ/m ²	
23°C	< 10	< 10	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	45	45	kJ/m ²	
23°C	50	55	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	250	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	230	--	°C	ISO 75-2/A
Melting Temperature ⁸	260	--	°C	ISO 11357-3
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 to 6.0		hr	
Processing (Melt) Temp	280 to 300		°C	
Mold Temperature	80.0 to 120		°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 bar			
4.	60x60x2mm			
5.	2.0 mm/min			
6.	2.0 mm/min			
7.	2 mm/min			
8.	10°C/min			

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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