

Durethan® AKV 35 CX H2.0 900876

Polyamide 66

LANXESS Asia/Pacific

Message:

PA 66, 35 % glass fibers, injection molding, heat aging stabilized

General Information			
Filler / Reinforcement	Glass Fiber,35% Filler by Weight		
Agency Ratings	EC 1907/2006 (REACH)		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.41	g/cm ³	ISO 1183
Molding Shrinkage			ISO 2577
Across Flow : 290°C, 2.00 mm ¹	0.90	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.070	%	
Flow : 290°C, 2.00 mm ³	0.30	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.070	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	11000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	197	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.8	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	10900	MPa	ISO 178/A
Flexural Stress ⁶ (23°C)	296	MPa	ISO 178/A
Flexural Strain at Flexural Strength ⁷ (23°C)	3.2	%	ISO 178/A
ISO Shortname	PA 66, GHR, 12-110, GF35		ISO 1874
Residual Moisture Content	0.020 to 0.070	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	58	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	> 240	°C	ISO 75-2/A
Melting Temperature ⁸	260	°C	ISO 11357-3
Injection	Nominal Value	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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