

Durethan® AKV325H2.0

PA66—GF25

25% Glass Fiber Reinforced, Blow Molding Grade, Extrusion, Heat Stabilized, Hydrolysis Stabilized

Print Date: 2025-08-21

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES		DRY / COND	
Molding shrinkage (parallel)	0.8 / *	%	ISO 294-4
Molding shrinkage (normal)	0.8 / *	%	ISO 294-4
MECHANICAL PROPERTIES		DRY / COND	
Tensile modulus	8200 / 5000	MPa	ISO 527-1/-2
Stress at break	150 / 100	MPa	ISO 527-1/-2
Strain at break	3.8 / 10	%	ISO 527-1/-2
Flexural modulus	7200 / 4200	MPa	ISO 178
Flexural strength	240 / 140	MPa	ISO 178
Tensile modulus (200°C)	2670	MPa	ISO 527-1/-2
Charpy impact strength (+23°C)	80 / 90	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	65 / 65	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 15	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	<10 / <10	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	10 / 15	kJ/m²	ISO 180/1A
THERMAL PROPERTIES		DRY / COND	
Melting temperature (10°C/min)	261 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	236 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.3 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1 / *	E-4/°C	ISO 11359-1/-2
Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10

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Glow Wire Flammability Index GWFI	600 / –	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	2 / –	mm	IEC 60695-2-12
ELECTRICAL PROPERTIES		DRY / COND	
Relative permittivity (100Hz)	4.2 / –	–	IEC 62631-2-1
Relative permittivity (1 MHz)	3.8 / –	–	IEC 62631-2-1
Dissipation factor (100 Hz)	100 / –	E-4	IEC 62631-2-1
Dissipation factor (1 MHz)	180 / –	E-4	IEC 62631-2-1
Volume resistivity	1E13 / –	Ohm*m	IEC 62631-3-1
Surface resistivity	1E14 / –	Ohm	IEC 62631-3-2
Electric strength	32 / –	kV/mm	IEC 60243-1
Comparative tracking index	425 / –	V	IEC 60112
OTHER PROPERTIES		DRY / COND	
Water absorption	6.6 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1310 / –	kg/m³	ISO 1183
MATERIAL SPECIFIC PROPERTIES		DRY / COND	
Viscosity number	210 / *	cm³/g	ISO 307, 1157, 1628
PROCESSING RECOMMENDATIONS		VALUE	
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	280-300	°C	
Mold temperature	80-120	°C	

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