

# Durethan® BKV115H3.0 DUS008

## PA6—I—GF15

15% Glass Reinforced, Injection Molding, Heat Stabilized, Improved Impact

| PROPERTIES                                | TYPICAL DATA      | UNIT  | TEST METHOD     |
|-------------------------------------------|-------------------|-------|-----------------|
| <b>RHEOLOGICAL PROPERTIES</b>             |                   |       |                 |
|                                           | <b>DRY / COND</b> |       |                 |
| Molding shrinkage (parallel)              | 0.45 / *          | %     | ISO 294-4       |
| Molding shrinkage (normal)                | 0.55 / *          | %     | ISO 294-4       |
| <b>MECHANICAL PROPERTIES</b>              |                   |       |                 |
|                                           | <b>DRY / COND</b> |       |                 |
| Tensile modulus                           | 5600 / 2800       | MPa   | ISO 527-1/-2    |
| Stress at break                           | 115 / 65          | MPa   | ISO 527-1/-2    |
| Strain at break                           | 4 / 12            | %     | ISO 527-1/-2    |
| Flexural modulus                          | 4900 / 2500       | MPa   | ISO 178         |
| Flexural strength                         | 185 / 95          | MPa   | ISO 178         |
| Charpy impact strength (+23°C)            | 65 / 80           | kJ/m² | ISO 179/1eU     |
| Charpy impact strength (-30°C)            | 50 / -            | 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     |
| <b>THERMAL PROPERTIES</b>                 |                   |       |                 |
|                                           | <b>DRY / COND</b> |       |                 |
| Melting temperature (10°C/min)            | 220 / *           | °C    | ISO 11357-1/-3  |
| Temp. of deflection under load (1.80 MPa) | 195 / *           | °C    | ISO 75-1/-2     |
| Temp. of deflection under load (0.45 MPa) | 215 / *           | °C    | ISO 75-1/-2     |
| Burning Behav. at 1.5 mm nom. thickn.     | HB / *            | class | IEC 60695-11-10 |
| Burning Behav. at 3.0 mm nom. thickn.     | HB / *            | class | IEC 60695-11-10 |
| Burning Behav. at 0.75 mm nom. thickn.    | HB / *            | class | IEC 60695-11-10 |
| Glow Wire Ignition Temperature GWIT       | 725 / -           | °C    | IEC 60695-2-13  |
| GWIT (Thickness (1) tested)               | 0.75 / -          | mm    | IEC 60695-2-13  |

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|-------------------------------------|--------------|------|----------------|
| Glow Wire Ignition Temperature GWIT | 700 / –      | °C   | IEC 60695–2–13 |
| GWIT (Thickness (2) tested)         | 1.5 / –      | mm   | IEC 60695–2–13 |

| OTHER PROPERTIES | DRY / COND |       |          |
|------------------|------------|-------|----------|
| Density          | 1230 / –   | kg/m³ | ISO 1183 |

| 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)   | 260–290   | °C |                      |
| Mold temperature                 | 80–100    | °C |                      |