Property Data

Envalior
Imagine the Future

Durethan® BKV235H2.0XCP

PA6-I-GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized, Improved Impact

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	**DRY / COND**		
Molding shrinkage (parallel)	0.25 / *	%	ISO 294-4
Molding shrinkage (normal)	0.65 / *	%	ISO 294-4
MECHANICAL PROPERTIES	**DRY / COND**		
Tensile modulus	9500 / 5700	MPa	ISO 527-1/-2
Stress at break	165 / 110	MPa	ISO 527-1/-2
Strain at break	5.5 / 11.5	%	ISO 527-1/-2
Flexural modulus	8900 / 5600	MPa	ISO 178
Flexural strength	260 / 155	MPa	ISO 178
Tensile modulus (200°C)	2940	MPa	ISO 527-1/-2
Charpy impact strength (+23°C)	110 / 125	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	120 / 110	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	28 / 40	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	18 / 17	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	27 / 42	kJ/m²	ISO 180/1A
THERMAL PROPERTIES	**DRY / COND**		
Melting temperature (10°C/min)	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	203 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.15 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.2 / *	E-4/°C	ISO 11359-1/-2

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
OTHER PROPERTIES	**DRY / COND**		
Density	1360 / –	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)	280–300	°C	
Mold temperature	80–100	°C	