

Durethan® BKV30FN04 DUS064

PA6—GF30 FR(40)

30% Glass Reinforced, Injection Molding, Flame Retardant (halogen free), Heat Stabilized

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.2 / *	%	ISO 294-4
Molding shrinkage (normal)	0.7 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	11000 / 7000	MPa	ISO 527-1/-2
Stress at break	140 / 95	MPa	ISO 527-1/-2
Strain at break	3.1 / 6	%	ISO 527-1/-2
Flexural modulus	10200 / 6600	MPa	ISO 178
Flexural strength	235 / 160	MPa	ISO 178
Charpy impact strength (+23°C)	60 / 70	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 13	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / 13	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	219 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.2 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	0.8 / *	E-4/°C	ISO 11359-1/-2
Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10

Property Data

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695–2–12
GWFI (Thickness (1) tested)	1.5 / –	mm	IEC 60695–2–12
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695–2–12
GWFI (Thickness (2) tested)	3 / –	mm	IEC 60695–2–12

ELECTRICAL PROPERTIES	DRY / COND		
Electric strength	35 / –	kV/mm	IEC 60243–1
Comparative tracking index	600 / –	V	IEC 60112

OTHER PROPERTIES	DRY / COND		
Water absorption	4.8 / *	%	Sim. to ISO 62
Humidity absorption	1.6 / *	%	Sim. to ISO 62
Density	1420 / –	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	0.03–0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	250–280	°C	
Mold temperature	70–90	°C	