

Durethan® BKV35XTS1

PA6—GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.25 / *	%	ISO 294-4
Molding shrinkage (normal)	0.75 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	10700 / 6500	MPa	ISO 527-1/-2
Stress at break	180 / 100	MPa	ISO 527-1/-2
Strain at break	3 / 5	%	ISO 527-1/-2
Flexural modulus	10500 / 6500	MPa	ISO 178
Flexural strength	275 / 160	MPa	ISO 178
Tensile modulus (200°C)	3530	MPa	ISO 527-1/-2
Charpy impact strength (+23°C)	70 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	60 / 55	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	12 / 20	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	<10 / <10	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	12 / 20	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)	205 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.17 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1 / *	E-4/°C	ISO 11359-1/-2

OTHER PROPERTIES

DRY / COND

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Density	1410 / –	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)	270–290	°C	
Mold temperature	80–100	°C	
admissible residence time at Tmax	<5	min	