

Durethan® BKV55XF

PA6—GF55

55% Glass Reinforced, Injection Molding, Heat Stabilized, Improved flow

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.2 / *	%	ISO 294-4
Molding shrinkage (normal)	0.5 / *	%	ISO 294-4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	17300 / 10500	MPa	ISO 527-1/-2
Stress at break	215 / 140	MPa	ISO 527-1/-2
Strain at break	2.5 / 3.5	%	ISO 527-1/-2
Flexural modulus	16500 / 11000	MPa	ISO 178
Flexural strength	330 / 210	MPa	ISO 178
Charpy impact strength (+23°C)	90 / 85	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	15 / 20	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	15 / 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)	208 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	218 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.12 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	0.9 / *	E-4/°C	ISO 11359-1/-2
OTHER PROPERTIES	DRY / COND		
Density	1620 / -	kg/m³	ISO 1183

Property Data

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2–6	h	
Residual moisture content	0.05–0.15	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	270–290	°C	
Mold temperature	80–120	°C	