

Durethan® BLUEBKV325ZH2.0

PA6—I—GF25

25% Glass Reinforced, Blow Molding Grade, Heat Stabilized, Improved Impact, Recycled Content

Sustainability

Bio-based
 Mass balanced
 Recycled based

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.7 / *	%	ISO 294-4
Molding shrinkage (normal)	0.7 / *	%	ISO 294-4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	8000 / 4000	MPa	ISO 527-1/-2
Stress at break	130 / 70	MPa	ISO 527-1/-2
Strain at break	3.2 / 8.5	%	ISO 527-1/-2
Flexural modulus	6900 / 3600	MPa	ISO 178
Flexural strength	200 / 110	MPa	ISO 178
Charpy impact strength (+23°C)	75 / 95	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	85 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	15 / 30	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	10 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	15 / 30	kJ/m²	ISO 180/1A
THERMAL PROPERTIES	DRY / COND		
Melting temperature (10°C/min)	219 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	210 / *	°C	ISO 75-1/-2

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Coeff. of linear therm. expansion (parallel)	0.3 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.3 / *	E-4/°C	ISO 11359-1/-2

OTHER PROPERTIES	DRY / COND		
Density	1280 / –	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	80–120	°C	