

# Durethan® DPBKV60EF

## PA6—GF60

60% Glass Reinforced, Injection Molding, Improved flow

| PROPERTIES                                   | TYPICAL DATA      | UNIT   | TEST METHOD     |
|----------------------------------------------|-------------------|--------|-----------------|
| <b>RHEOLOGICAL PROPERTIES</b>                |                   |        |                 |
|                                              | <b>DRY / COND</b> |        |                 |
| Molding shrinkage (parallel)                 | 0.25 / *          | %      | ISO 294-4       |
| Molding shrinkage (normal)                   | 0.35 / *          | %      | ISO 294-4       |
| <b>MECHANICAL PROPERTIES</b>                 |                   |        |                 |
|                                              | <b>DRY / COND</b> |        |                 |
| Tensile modulus                              | 20000 / 12500     | MPa    | ISO 527-1/-2    |
| Stress at break                              | 230 / 158         | MPa    | ISO 527-1/-2    |
| Strain at break                              | 2.5 / 3.5         | %      | ISO 527-1/-2    |
| Flexural modulus                             | 20200 / 13700     | MPa    | ISO 178         |
| Flexural strength                            | 390 / 260         | MPa    | ISO 178         |
| Charpy impact strength (+23°C)               | 95 / 95           | kJ/m²  | ISO 179/1eU     |
| Charpy impact strength (-30°C)               | 95 / 95           | kJ/m²  | ISO 179/1eU     |
| Charpy notched impact strength (+23°C)       | 17 / 24           | kJ/m²  | ISO 179/1eA     |
| Charpy notched impact strength (-30°C)       | 17 / -            | kJ/m²  | ISO 179/1eA     |
| Izod notched impact strength (+23°C)         | 18 / 28           | kJ/m²  | ISO 180/1A      |
| <b>THERMAL PROPERTIES</b>                    |                   |        |                 |
|                                              | <b>DRY / COND</b> |        |                 |
| Melting temperature (10°C/min)               | 221 / *           | °C     | ISO 11357-1/-3  |
| Temp. of deflection under load (1.80 MPa)    | 213 / *           | °C     | ISO 75-1/-2     |
| Temp. of deflection under load (0.45 MPa)    | 222 / *           | °C     | ISO 75-1/-2     |
| Coeff. of linear therm. expansion (parallel) | 0.1 / *           | 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 3.0 mm nom. thickn.        | HB / *            | 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          |
|----------------------------------------|--------------|-------|----------------------|
| Burning Behav. at 0.75 mm nom. thickn. | HB / *       | class | IEC 60695-11-10      |
| Thickness tested                       | 0.75 / *     | mm    | IEC 60695-11-10      |
| <b>ELECTRICAL PROPERTIES</b>           |              |       |                      |
|                                        | DRY / COND   |       |                      |
| Comparative tracking index             | 600 / –      | V     | IEC 60112            |
| <b>OTHER PROPERTIES</b>                |              |       |                      |
|                                        | DRY / COND   |       |                      |
| Water absorption                       | 3.7 / *      | %     | Sim. to ISO 62       |
| Humidity absorption                    | 1.2 / *      | %     | Sim. to ISO 62       |
| Density                                | 1720 / –     | kg/m³ | ISO 1183             |
| <b>PROCESSING RECOMMENDATIONS</b>      |              |       |                      |
|                                        | 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    |                      |