Property Data

Envalior
Imagine the Future

Durethan® DPBKV60EFW1

PA6–GF60

60% Glass Reinforced, Injection Molding, Improved flow

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.25 / *	%	ISO 294–4
Molding shrinkage (normal)	0.35 / *	%	ISO 294–4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	20000 / 12500	MPa	ISO 527–1/–2
Stress at break	230 / 155	MPa	ISO 527–1/–2
Strain at break	2.5 / 3.5	%	ISO 527–1/–2
Flexural modulus	20200 / –	MPa	ISO 178
Flexural strength	390 / –	MPa	ISO 178
Charpy impact strength (+23°C)	95 / –	kJ/m²	ISO 179/1eU
Charpy impact strength (–30°C)	95 / –	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	17 / –	kJ/m²	ISO 179/1eA
Charpy notched impact strength (–30°C)	17 / –	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	18 / –	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)	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
OTHER PROPERTIES	DRY / COND		

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Density	1700 / –	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	0.05–0.15	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	270–290	°C	
Mold temperature	80–120	°C	