

**Durethan® B38FKA 000000**  
**PA6**

Envalior

Film Extrusion, Unreinforced, Extrusion, Food Contact Quality, Medium Viscosity, Nucleated

ISO 1043 PA6

| Rheological properties     | dry / cond | Unit                   | Test Standard |
|----------------------------|------------|------------------------|---------------|
| <b>ISO Data</b>            |            |                        |               |
| Melt volume-flow rate, MVR | 5 / *      | cm <sup>3</sup> /10min | ISO 1133      |
| Temperature                | 235 / *    | °C                     | -             |
| Load                       | 2.16 / *   | kg                     | -             |

| Mechanical Properties                   | dry / cond          | Unit              | Test Standard |
|-----------------------------------------|---------------------|-------------------|---------------|
| <b>ISO Data</b>                         |                     |                   |               |
| Tensile Modulus                         | 2800 / 800          | MPa               | ISO 527       |
| Yield stress                            | 75 / 35             | MPa               | ISO 527       |
| Yield strain                            | 4 / 25              | %                 | ISO 527       |
| Nominal strain at break                 | 20 / >50            | %                 | ISO 527       |
| Impact Strength (Charpy), +23°C         | no break / no break | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Impact Strength (Charpy), -30°C         | no break / no break | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Notched Impact Strength (Charpy), +23°C | 5 / 50              | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Notched Impact Strength (Charpy), -30°C | 5 / -               | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Flexural Modulus (23°C)                 | 2600 / 700          | MPa               | ISO 178       |
| Notched Impact Strength (Izod), 23°C    | 7 / 50              | kJ/m <sup>2</sup> | ISO 180/1A    |
| Notched Impact Strength (Izod)          | 7 / 7.5             | kJ/m <sup>2</sup> | ISO 180/1A    |
| Temperature                             | -30                 | °C                | -             |
| Ball Indentation Hardness               | 130 / 40            | MPa               | ISO 2039-1    |

| Thermal Properties                          | dry / cond | Unit  | Test Standard  |
|---------------------------------------------|------------|-------|----------------|
| <b>ISO Data</b>                             |            |       |                |
| Melting Temperature (10°C/min)              | 222 / *    | °C    | ISO 11357-1/-3 |
| Temp. of deflection under load (1.80 MPa)   | 50 / *     | °C    | ISO 75-1/-2    |
| Temp. of deflection under load (0.45 MPa)   | 150 / *    | °C    | ISO 75-1/-2    |
| Coeff. of Linear Therm. Expansion, parallel | 80 / *     | E-6/K | ISO 11359-1/-2 |
| Coeff. of Linear Therm. Expansion, normal   | 80 / *     | E-6/K | ISO 11359-1/-2 |
| Burning Behav. at 1.5 mm Nom. Thickn.       | HB / *     | class | UL 94          |
| Thickness tested                            | 1.5 / *    | mm    | -              |
| Oxygen index                                | 24 / *     | %     | ISO 4589-1/-2  |

| Electrical Properties        | dry / cond  | Unit  | Test Standard |
|------------------------------|-------------|-------|---------------|
| <b>ISO Data</b>              |             |       |               |
| Relative permittivity, 100Hz | 3.9 / 18    | -     | IEC 62631-2-1 |
| Relative permittivity, 1MHz  | 3.5 / 4     | -     | IEC 62631-2-1 |
| Volume Resistivity           | 1E12 / 1E10 | Ohm*m | IEC 62631-3-1 |
| Surface Resistivity          | * / 1E13    | Ohm   | IEC 62631-3-2 |
| Electric Strength            | 30 / 35     | kV/mm | IEC 60243-1   |
| Comparative tracking index   | 600 / -     | -     | IEC 60112     |

| Other Properties    | dry / cond | Unit              | Test Standard  |
|---------------------|------------|-------------------|----------------|
| <b>ISO Data</b>     |            |                   |                |
| Water Absorption    | 10 / *     | %                 | Sim. to ISO 62 |
| Humidity absorption | 3 / *      | %                 | Sim. to ISO 62 |
| Density             | 1140 / -   | kg/m <sup>3</sup> | ISO 1183       |
| Bulk density        | 700        | kg/m <sup>3</sup> | -              |

| Test specimen production            | Value | Unit | Test Standard |
|-------------------------------------|-------|------|---------------|
| <b>ISO Data</b>                     |       |      |               |
| Injection Molding, melt temperature | 260   | °C   | ISO 294       |
| Injection Molding, mold temperature | 40    | °C   | ISO 294       |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---------------------------------------------|-------|------|---------------|
| Pre-drying - Temperature                    | 80    | °C   | -             |
| Pre-drying - Time                           | 2 - 6 | h    | -             |

## Characteristics

### Processing

Film Extrusion, Other Extrusion

### Features

Nucleated

### Delivery form

Pellets

### Certifications

Food approval

## Injection Molding

### PREPROCESSING

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

### PROCESSING

## Disclaimer

### Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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