

Durethan® BKV130H2.0 901510 DUS008
PA6-I-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA6-I-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	9300 / 5200	MPa	ISO 527
Stress at Break	160 / 100	MPa	ISO 527
Strain at Break	4 / 8	%	ISO 527
Impact Strength (Charpy), +23°C	90 / 90	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	75 / 75	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	13 / 20	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	990 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	765 / -	N	ISO 6603-2
Puncture energy, +23°C	4.3 / -	J	ISO 6603-2
Puncture energy, -30°C	2.5 / -	J	ISO 6603-2
Flexural Modulus (23°C)	8600 / 4700	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	15 / 22	kJ/m ²	ISO 180/1A
Notched Impact Strength (Izod)	10 / 10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	80 / 85	kJ/m ²	ISO 180/1U
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	202 / *	°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	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2
Other Properties			
ISO Data			
Water Absorption	6.6 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1360 / -	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
Value Unit Test Standard			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

Impact modified, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 260 - 290 °C

Mold temperature: 80 - 100 °C

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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