Durethan® BKV230 000000 DUS008

PA6-I-GF30 Envalior

Injection Molding, 30% Glass Reinforced, 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	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8500 / 4200	MPa	ISO 527
Stress at Break	130 / 80	MPa	ISO 527
Strain at Break	4.1 / 8.6	%	ISO 527
Impact Strength (Charpy), +23°C	85 / 100	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	95 / 90	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 37	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	13 / 13	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	7400 / 4200	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	20 / 35	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	15 / 15	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	75 / 95	kJ/m²	ISO 180/1U

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	198 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	218 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-

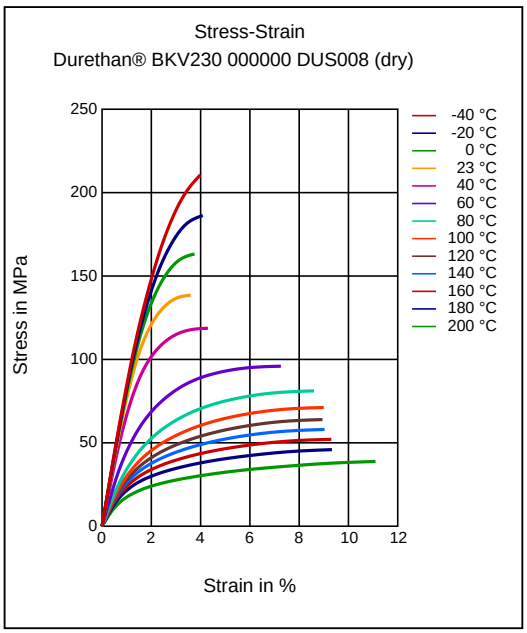
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1320 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

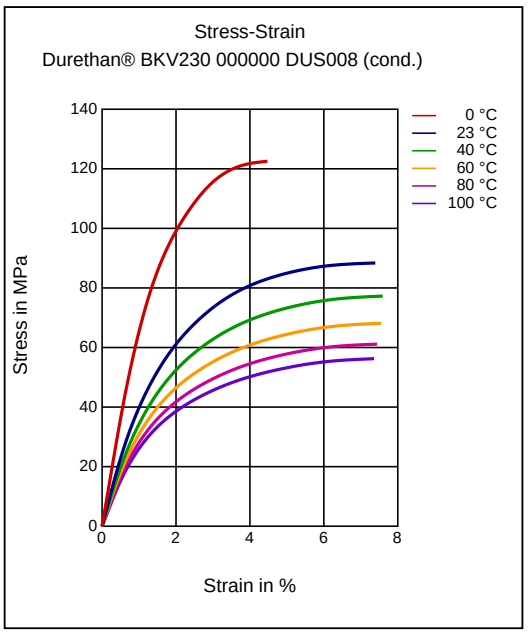
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

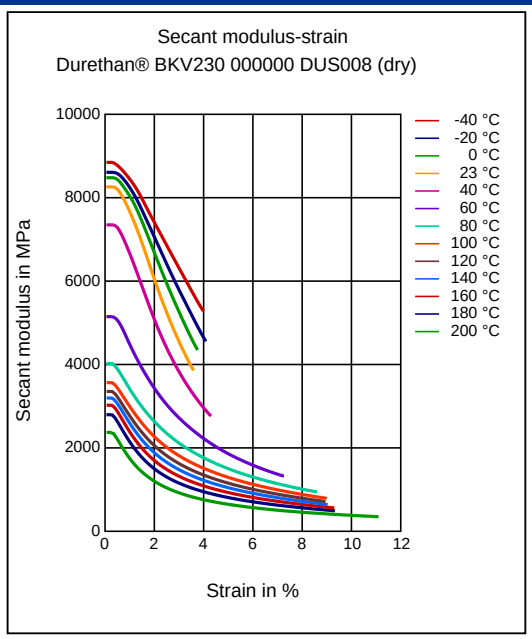
Stress-strain



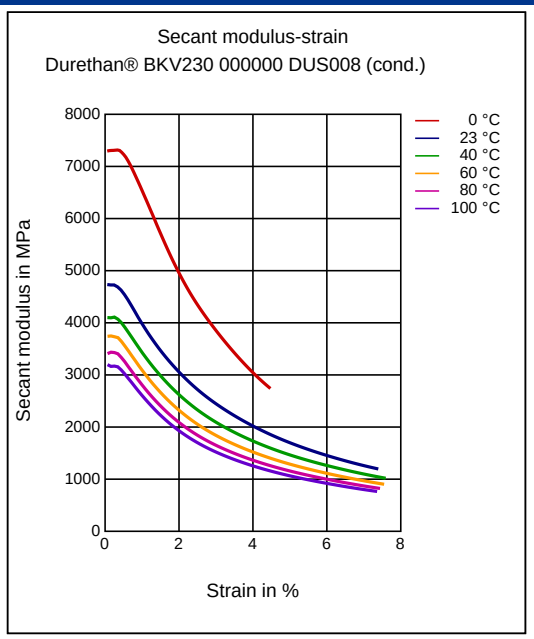
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing
Injection Molding

Special Characteristics
Impact modified

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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