

**Durethan® BKV25FN27 000000**  
**PA6-GX25 FR(30+30)**

Envalior

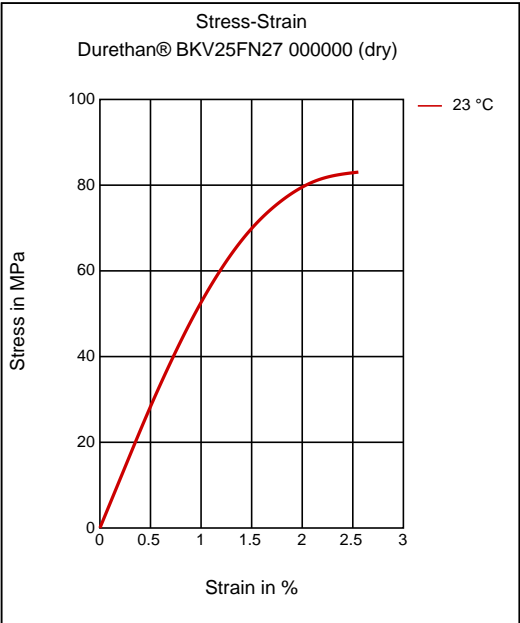
Injection Molding, 25% Glass Reinforced, Flame Retardant (halogen free), Heat Stabilized

ISO 1043 PA6-GX25 FR(30)

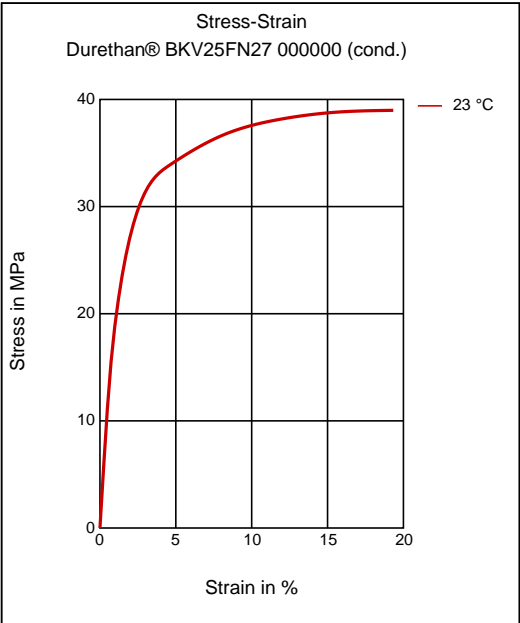
Rheological properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
<b>Mechanical Properties</b>			
<b>ISO Data</b>			
Tensile Modulus	5600 / 2300	MPa	ISO 527
Stress at Break	85 / 40	MPa	ISO 527
Strain at Break	3.2 / 25	%	ISO 527
Impact Strength (Charpy), +23°C	30 / 70	kJ/m <sup>2</sup>	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA
Flexural Modulus (23°C)	5100 / 2300	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / 10	kJ/m <sup>2</sup>	ISO 180/1A
Notched Impact Strength (Izod)	10 / 10	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	25 / 60	kJ/m <sup>2</sup>	ISO 180/1U
Ball Indentation Hardness	180 / -	MPa	ISO 2039-1
<b>Thermal Properties</b>			
<b>ISO Data</b>			
Melting Temperature (10°C/min)	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	170 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	210 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	50 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	90 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-2 / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Oxygen index	27 / *	%	ISO 4589-1/-2
<b>Electrical Properties</b>			
<b>ISO Data</b>			
Volume Resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Electric Strength	30 / -	kV/mm	IEC 60243-1
Comparative tracking index	550 / -	-	IEC 60112
<b>Other Properties</b>			
<b>ISO Data</b>			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2.1 / *	%	Sim. to ISO 62
Density	1340 / -	kg/m <sup>3</sup>	ISO 1183
<b>Test specimen production</b>			
<b>ISO Data</b>			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
<b>Processing Recommendation Injection Molding</b>			
<b>Value</b>			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

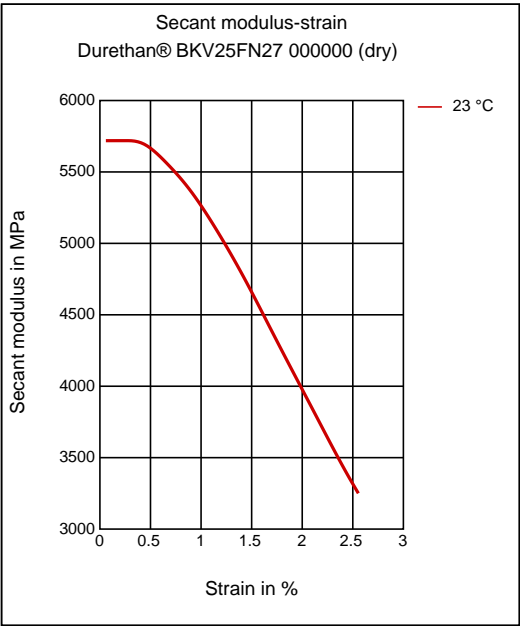
Stress-strain



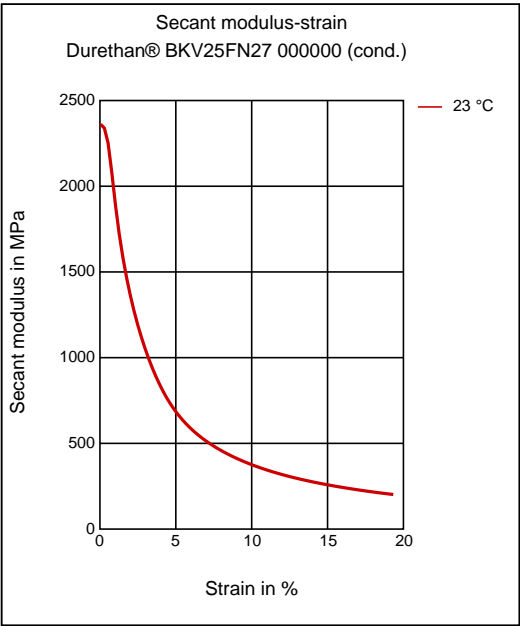
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Special Characteristics

Flame retardant, Halogen-free, Heat aging stabilized

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

#### PROCESSING

Melt temperature (Tmin - Tmax): 250 - 270 °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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