

**Durethan® BKV30XWPLT 904040**  
**PA6-GF30**

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Laser Weldable, Laser Transparent Black

ISO 1043 PA6-GF30

Rheological properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3 / *	%	ISO 294-4, 2577
Mechanical Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	9500 / 7250	MPa	ISO 527
Stress at Break	175 / 120	MPa	ISO 527
Strain at Break	3.6 / 5.8	%	ISO 527
Puncture energy, +23°C	2.9 / 4.2	J	ISO 6603-2
Puncture energy, -30°C	3.1 / -	J	ISO 6603-2
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)	188 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2
Other Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Density	1360 / -	kg/m³	ISO 1183
Material Specific Properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Viscosity number	125 / *	cm³/g	ISO 307, 1157, 1628
Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
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	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

**Characteristics**
**Processing**

Injection Molding

**Additives**

Release agent

**Delivery form**

Pellets

**Special Characteristics**

Heat aging stabilized

**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): 270 - 290 °C

Mold temperature: 80 - 120 °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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