

Durethan® BKV35H2.0 901510
PA6-GF35

Envalior

Injection Molding, 35% Glass Reinforced, Heat Stabilized

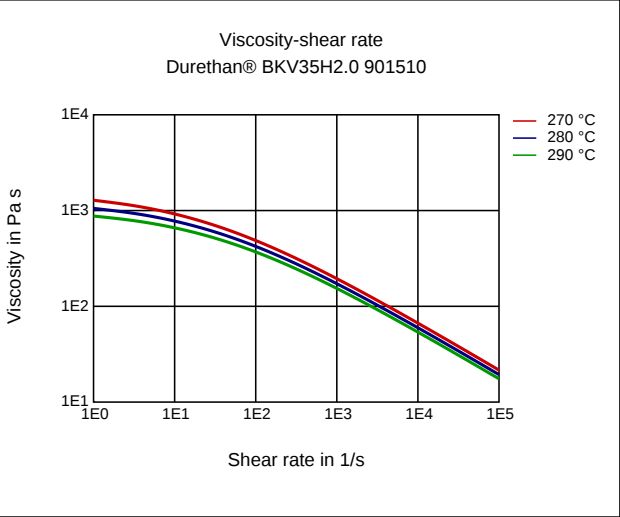
ISO 1043 PA6-GF35

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	11000 / 6500	MPa	ISO 527
Stress at Break	185 / 110	MPa	ISO 527
Strain at Break	3.3 / 6.5	%	ISO 527
Tensile Creep Modulus, 1h	* / 6000	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 4900	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	90 / 100	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	75 / 70	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	12 / 20	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	1060 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	945 / -	N	ISO 6603-2
Puncture energy, +23°C	3.9 / -	J	ISO 6603-2
Puncture energy, -30°C	3.3 / -	J	ISO 6603-2
Flexural Modulus (23°C)	10500 / 6200	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	15 / 20	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	10 / 10	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	80 / 90	kJ/m²	ISO 180/1U
Ball Indentation Hardness	230 / 120	MPa	ISO 2039-1
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°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	95 / *	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	23 / *	%	ISO 4589-1/-2
Electrical Properties			
ISO Data			
Comparative tracking index	475 / -	-	IEC 60112
Other Properties			
ISO Data			
Water Absorption	6.5 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1410 / -	kg/m³	ISO 1183
Bulk density	700	kg/m³	-
Material Specific Properties			
ISO Data			
Viscosity number	140 / *	cm³/g	ISO 307, 1157, 1628
Test specimen production			
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

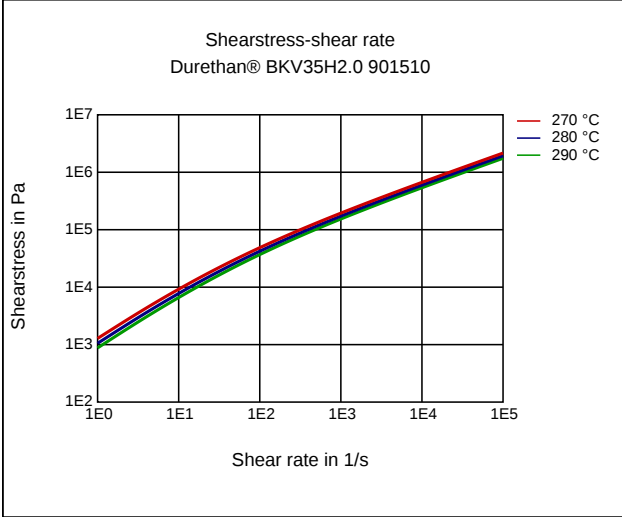
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

Diagrams

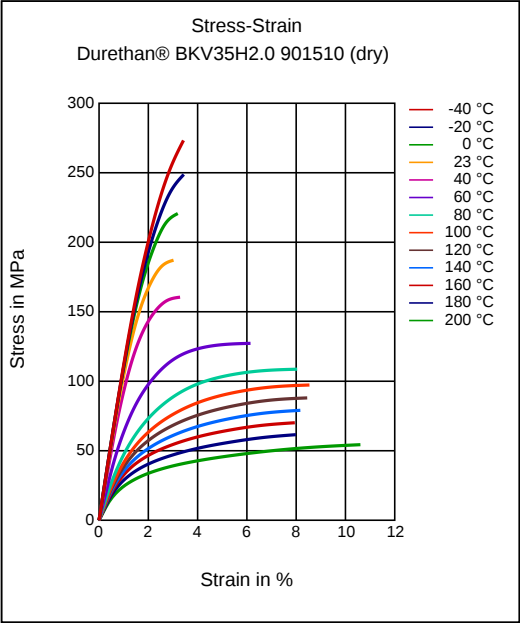
Viscosity-shear rate



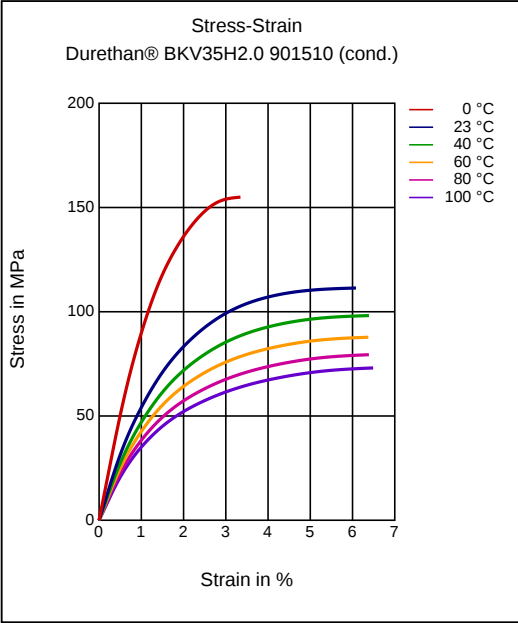
Shearstress-shear rate



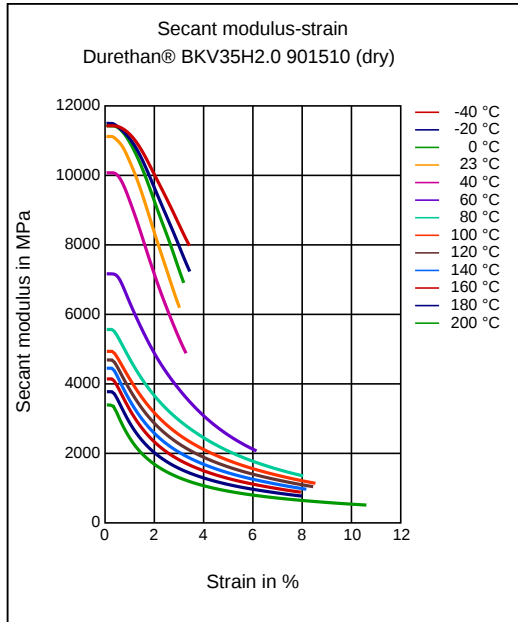
Stress-strain



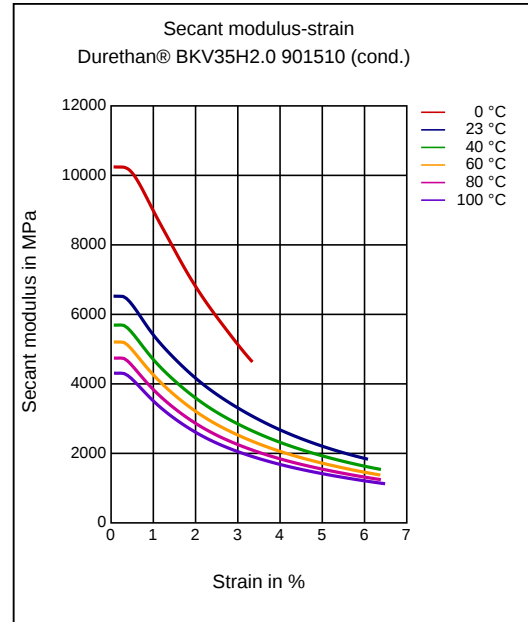
Stress-strain



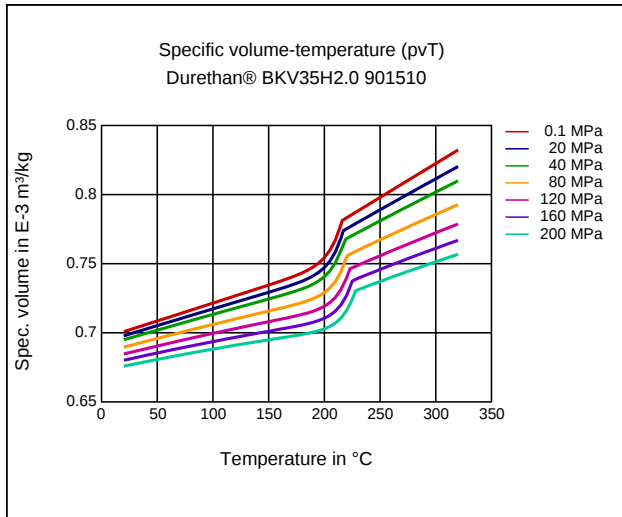
Secant modulus-strain



Secant modulus-strain



Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

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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