

Durethan® BKV60XF 900116
PA6-GF60

Envalior

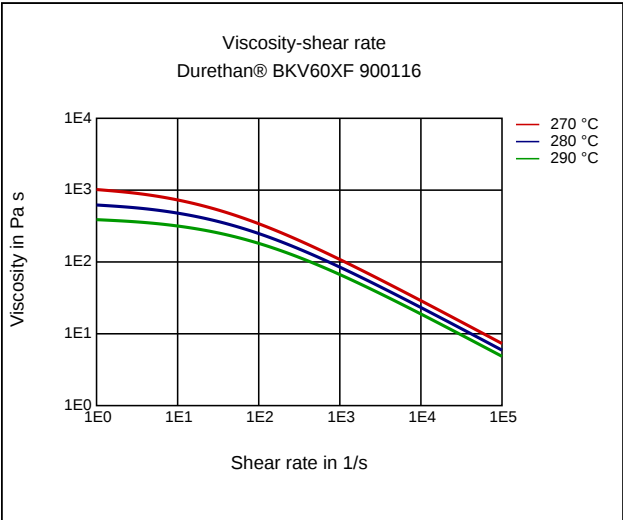
Injection Molding, 60% Glass Reinforced, Heat Stabilized, Improved flow

ISO 1043 PA6-GF60

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5 / *	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	20200 / 13000	MPa	ISO 527
Stress at Break	215 / 140	MPa	ISO 527
Strain at Break	2.3 / 2.8	%	ISO 527
Impact Strength (Charpy), +23°C	88 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	15 / -	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1100 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	950 / -	N	ISO 6603-2
Puncture energy, +23°C	4.2 / -	J	ISO 6603-2
Puncture energy, -30°C	3.4 / -	J	ISO 6603-2
Flexural Modulus (23°C)	18500 / 14000	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	15 / -	kJ/m ²	ISO 180/1A
Impact Strength (Izod), 23°C	80 / 75	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)	208 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	217 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	11 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	85 / *	E-6/K	ISO 11359-1/-2
Other Properties			
ISO Data			
Density	1690 / -	kg/m ³	ISO 1183
Bulk density	760	kg/m ³	-
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			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

Diagrams

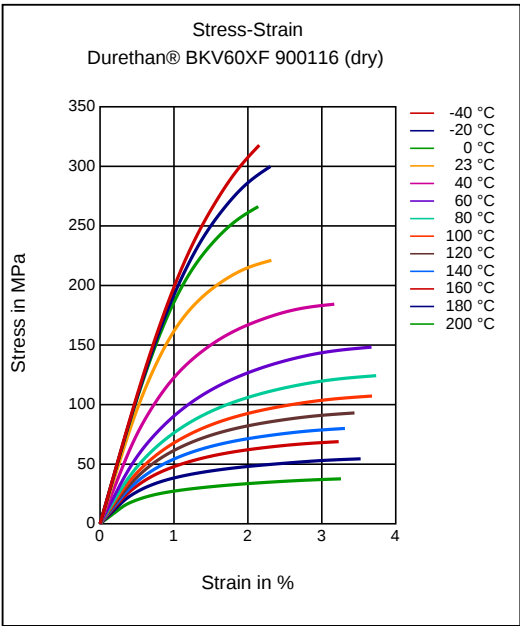
Viscosity-shear rate



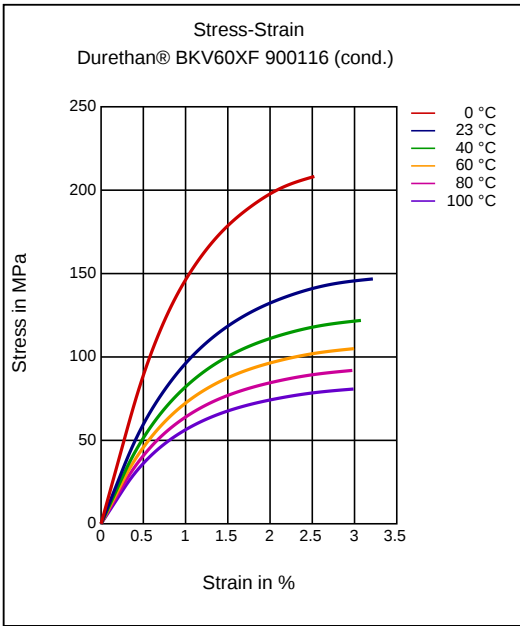
Shearstress-shear rate



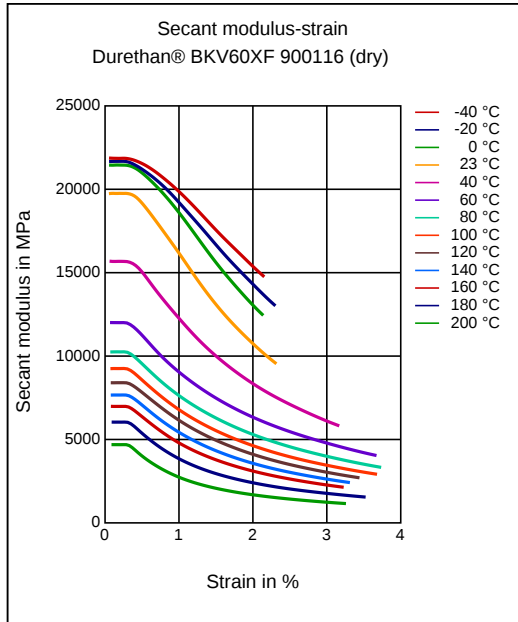
Stress-strain



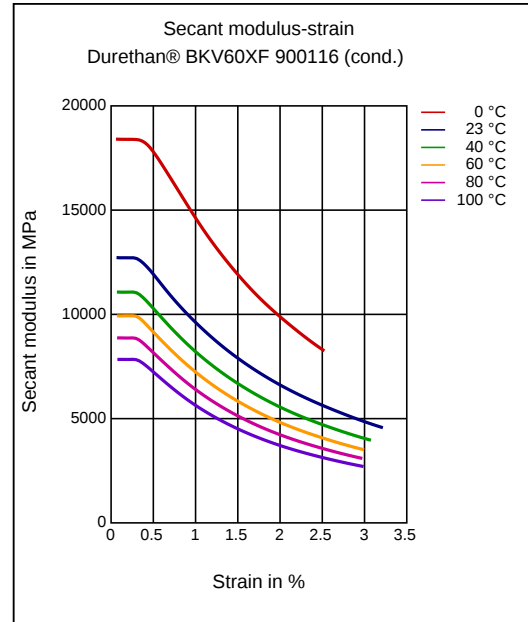
Stress-strain



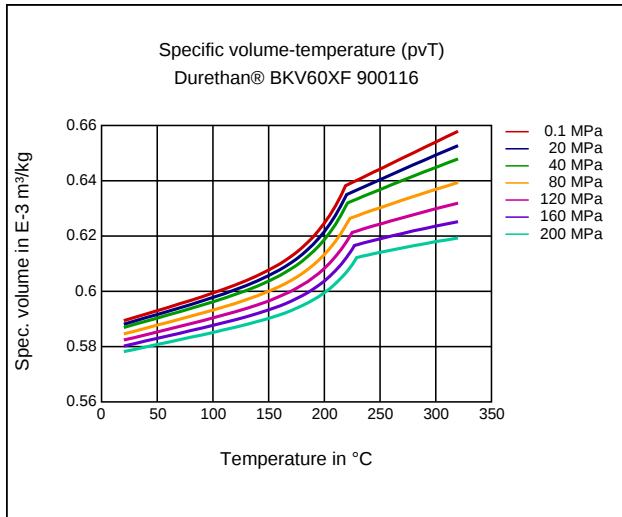
Secant modulus-strain



Secant modulus-strain



Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.05 - 0.15%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

Special Characteristics

Heat aging stabilized

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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- any bodily implant application for greater than 30 days
- any critical component in any medical device that supports or sustains human life.

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