

Durethan® BKV215H3.0 000000 PA*-GF15

Envalior

Injection Molding, 15% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA*-I-GF15

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	4500 / 2300	MPa	ISO 527
Stress at Break	85 / 50	MPa	ISO 527
Strain at Break	4.5 / 15	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 95	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	80 / 80	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 35	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	10 / 12	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1000 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	650 / -	N	ISO 6603-2
Puncture energy, +23°C	13 / -	J	ISO 6603-2
Puncture energy, -30°C	4.8 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	214 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	175 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	205 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	40 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	170 / *	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	22 / *	%	ISO 4589-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1180 / -	kg/m ³	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	-

Characteristics

Processing

Injection Molding

Special Characteristics

Impact modified, Heat aging stabilized

Delivery form

Pellets

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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
