

Durethan® B40SKW1 000000

PA6

Envalior

Injection Molding, Unreinforced

ISO 1043 PA6

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	3200 / 900	MPa	ISO 527
Yield stress	85 / 40	MPa	ISO 527
Yield strain	4 / 25	%	ISO 527
Nominal strain at break	20 / >50	%	ISO 527

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	55 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	180 / *	°C	ISO 75-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	10 / *	%	Sim. to ISO 62
Humidity absorption	3 / *	%	Sim. to ISO 62
Density	1140 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°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 - 80	°C	-
Mold temperature	80 - 100	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

UV stabilized

Delivery form

Pellets

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 - 280 °C

Mold temperature: 80 - 100 °C