

Durethan® BKV15 000000 DUS008
PA6-GF15

Envalior

Injection Molding, 15% Glass Reinforced

ISO 1043 PA6-GF15

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6500 / 3100	MPa	ISO 527
Stress at Break	130 / 65	MPa	ISO 527
Strain at Break	3 / 12	%	ISO 527
Impact Strength (Charpy), +23°C	50 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	45 / 45	kJ/m ²	ISO 179/1eU
Puncture - maximum force, +23°C	940 / -	N	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	195 / *	°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	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1230 / -	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	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

Characteristics
Processing

Injection Molding

Delivery form

Pellets

Injection Molding
PREPROCESSING

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