

Durethan® BKV50GW1 000000 DUS037
PA6-GF50

Envalior

Injection Molding, 50% Glass Reinforced

ISO 1043 PA6-GF50

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	16800 / 10200	MPa	ISO 527
Stress at Break	225 / 140	MPa	ISO 527
Strain at Break	3 / 5	%	ISO 527
Impact Strength (Charpy), +23°C	100 / 110	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	90 / 90	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 25	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	15 / 15	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1570 / -	kg/m ³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	140 / *	cm ³ /g	ISO 307, 1157, 1628

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	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

Characteristics
Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

UV 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