

Durethan® DPBKV60EF 000000
PA6-GF60

Envalior

 Injection Molding, 60% Glass Reinforced, 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	0.3 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	20000 / 12500	MPa	ISO 527
Stress at Break	230 / 158	MPa	ISO 527
Strain at Break	2.5 / 3.5	%	ISO 527
Impact Strength (Charpy), +23°C	95 / 95	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	95 / 95	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	17 / 24	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	17 / -	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	1370 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	1300 / -	N	ISO 6603-2
Puncture energy, +23°C	4.3 / -	J	ISO 6603-2
Puncture energy, -30°C	3.7 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	213 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	222 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	10 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	3.7 / *	%	Sim. to ISO 62
Humidity absorption	1.2 / *	%	Sim. to ISO 62
Density	1720 / -	kg/m³	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	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

Characteristics
Processing

Injection Molding

Delivery form

Pellets

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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

PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

Mold temperature: 80 - 120 °C
