

Durethan® BKV115H3.0

PA*—I—GF15

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

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.4 / *	%	ISO 294-4
Molding shrinkage (normal)	0.5 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	5600 / 2700	MPa	ISO 527-1/-2
Stress at break	110 / 55	MPa	ISO 527-1/-2
Strain at break	4.5 / 14	%	ISO 527-1/-2
Flexural modulus	5200 / 2400	MPa	ISO 178
Flexural strength	180 / 90	MPa	ISO 178
Tensile modulus (200°C)	1300	MPa	ISO 527-1/-2
Charpy impact strength (+23°C)	60 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	45 / 45	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 15	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	<10 / <10	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / 15	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	212 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	185 / *	°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)	0.3 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.2 / *	E-4/°C	ISO 11359-1/-2
Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10



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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.75 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Glow Wire Flammability Index GWFI	650 / –	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	2 / –	mm	IEC 60695-2-12

ELECTRICAL PROPERTIES	DRY / COND		
Comparative tracking index	600 / –	V	IEC 60112

OTHER PROPERTIES	DRY / COND		
Water absorption	8.5 / *	%	Sim. to ISO 62
Humidity absorption	2.5 / *	%	Sim. to ISO 62
Density	1230 / –	kg/m³	ISO 1183

MATERIAL SPECIFIC PROPERTIES	DRY / COND		
Viscosity number	134 / *	cm³/g	ISO 307, 1157, 1628

PROCESSING RECOMMENDATIONS	VALUE		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2–6	h	
Residual moisture content	0.03–0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	260–290	°C	
Mold temperature	80–100	°C	

