

Durethan® BKV215H3.0

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)	0.6 / *	%	ISO 294-4
Molding shrinkage (normal)	0.6 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	4500 / 2300	MPa	ISO 527-1/-2
Stress at break	85 / 50	MPa	ISO 527-1/-2
Strain at break	4.5 / 15	%	ISO 527-1/-2
Flexural modulus	4200 / 2300	MPa	ISO 178
Flexural strength	135 / 75	MPa	ISO 178
Charpy impact strength (+23°C)	70 / 95	kJ/m²	ISO 179/1eU
Charpy impact strength (-30°C)	80 / 80	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	20 / 35	kJ/m²	ISO 179/1eA
Charpy notched impact strength (-30°C)	10 / 12	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	20 / 35	kJ/m²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	214 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	175 / *	°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)	0.4 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.7 / *	E-4/°C	ISO 11359-1/-2
Burning Behav. at 3.0 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10



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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Burning Behav. at 0.75 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Oxygen index	22 / *	%	ISO 4589-1/-2

OTHER PROPERTIES	DRY / COND		
Water absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1180 / –	kg/m³	ISO 1183

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	

