Property Data

Envalior
Imagine the Future

Durethan® BKV35XTS1

PA6–GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	DRY / COND		
Molding shrinkage (parallel)	0.25 / *	%	ISO 294–4
Molding shrinkage (normal)	0.75 / *	%	ISO 294–4
MECHANICAL PROPERTIES	DRY / COND		
Tensile modulus	10700 / 6500	MPa	ISO 527–1/–2
Stress at break	180 / 100	MPa	ISO 527–1/–2
Strain at break	3 / 5	%	ISO 527–1/–2
Flexural modulus	10500 / 6500	MPa	ISO 178
Flexural strength	275 / 160	MPa	ISO 178
Tensile modulus (200°C)	3530	MPa	ISO 527–1/–2
Charpy impact strength (+23°C)	70 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength (–30°C)	60 / 55	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	12 / 20	kJ/m²	ISO 179/1eA
Charpy notched impact strength (–30°C)	<10 / <10	kJ/m²	ISO 179/1eA
Izod notched impact strength (+23°C)	12 / 20	kJ/m²	ISO 180/1A
THERMAL PROPERTIES	DRY / COND		
Melting temperature (10°C/min)	221 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75–1/–2
Coeff. of linear therm. expansion (parallel)	0.17 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	1 / *	E–4/°C	ISO 11359–1/–2
OTHER PROPERTIES	DRY / COND		

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PROPERTIES	*TYPICAL DATA*	*UNIT*	*TEST METHOD*
Density	1410 / –	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)	270–290	°C	
Mold temperature	80–100	°C	
admissible residence time at Tmax	<5	min	