

Durethan® BKV215W1 902176
PA*-GF15

Envalior

Injection Molding, 15% Glass Reinforced, Improved Impact

ISO 1043 PA*-I-GF15

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	4400 / 2100	MPa	ISO 527
Stress at Break	85 / 50	MPa	ISO 527
Strain at Break	4.7 / 20	%	ISO 527
Impact Strength (Charpy), +23°C	65 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	80 / 80	kJ/m ²	ISO 179/1eU
Puncture - maximum force, +23°C	1760 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	785 / -	N	ISO 6603-2
Puncture energy, +23°C	7.3 / -	J	ISO 6603-2
Puncture energy, -30°C	3.1 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	214 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	180 / *	°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	50 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	160 / *	E-6/K	ISO 11359-1/-2

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

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1180 / -	kg/m ³	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	≤0.12	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

Characteristics
Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Impact modified, UV stabilized

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

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Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 260 - 290 °C

Mold temperature: 80 - 100 °C
