

Durethan® BKV230H2.0 901510
PA*-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA*-I-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8100 / 4400	MPa	ISO 527
Stress at Break	130 / 80	MPa	ISO 527
Strain at Break	4 / 8	%	ISO 527
Impact Strength (Charpy), +23°C	90 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	95 / 95	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	25 / 45	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	20 / 20	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1280 / 1810	N	ISO 6603-2
Puncture - maximum force, -30°C	940 / 1080	N	ISO 6603-2
Puncture energy, +23°C	4.6 / 6.4	J	ISO 6603-2
Puncture energy, -30°C	2.9 / 3.2	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	213 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	200 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	130 / *	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	450 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	6 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1320 / -	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	-

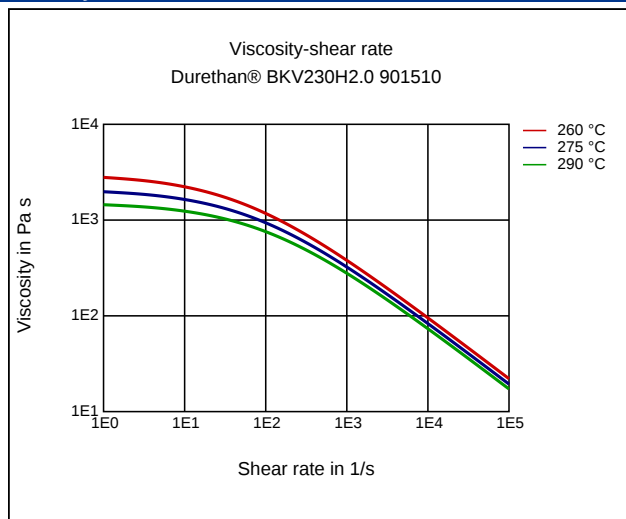
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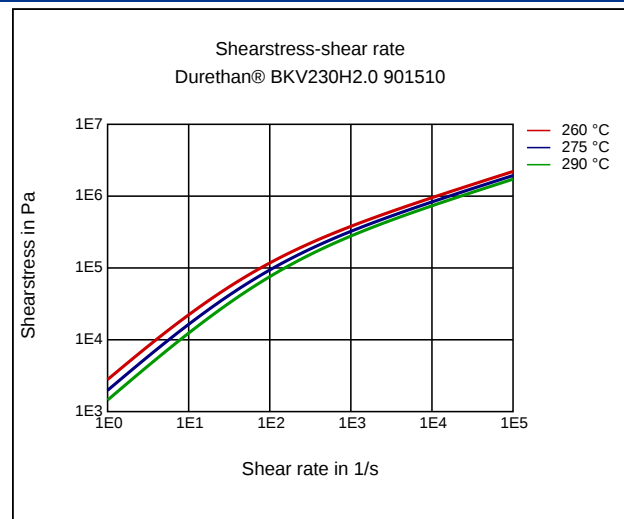
Envalior

Diagrams

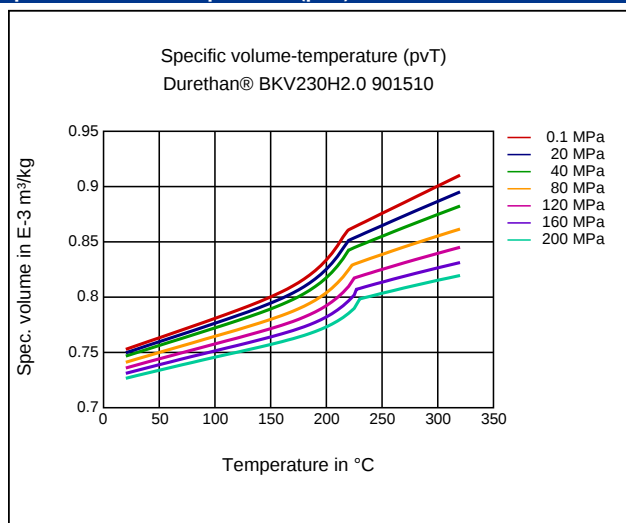
Viscosity-shear rate



Shearstress-shear rate



Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Impact modified, Heat aging stabilized

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

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