

Durethan® BKV130 901510 DUS008
PA6-I-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Improved Impact

ISO 1043 PA6-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	9300 / 5200	MPa	ISO 527
Stress at Break	155 / 95	MPa	ISO 527
Strain at Break	4 / 7.5	%	ISO 527
Impact Strength (Charpy), +23°C	90 / 90	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	70 / 75	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	930 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	750 / -	N	ISO 6603-2
Puncture energy, +23°C	4 / -	J	ISO 6603-2
Puncture energy, -30°C	2.6 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220 / *	°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	100 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	6.3 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1370 / -	kg/m³	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

Special Characteristics

Impact modified

Delivery form

Pellets

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