

Durethan® BKV235H2.0XCP 900111
PA6-I-GF35

Envalior

Injection Molding, 35% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA6-I-GF35

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9500 / 5700	MPa	ISO 527
Stress at Break	165 / 110	MPa	ISO 527
Strain at Break	5.5 / 11.5	%	ISO 527
Impact Strength (Charpy), +23°C	110 / 125	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	120 / 110	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	28 / 40	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	18 / 17	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1530 / 1770	N	ISO 6603-2
Puncture - maximum force, -30°C	1200 / 1240	N	ISO 6603-2
Puncture energy, +23°C	9 / 12	J	ISO 6603-2
Puncture energy, -30°C	5 / 5.5	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	203 / *	°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	15 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	120 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1360 / -	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

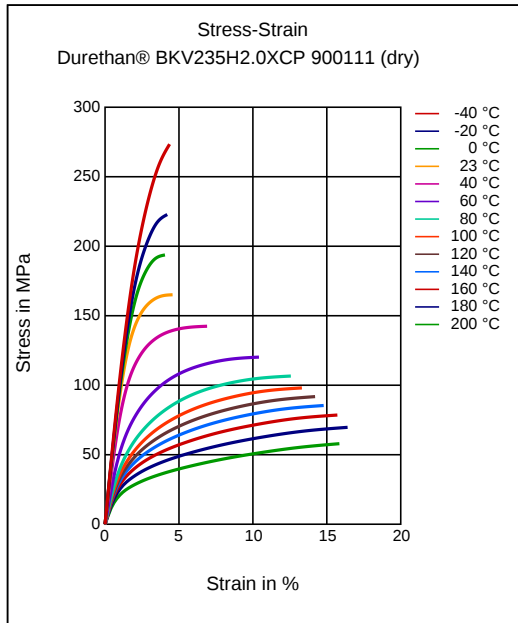
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 100	°C	-

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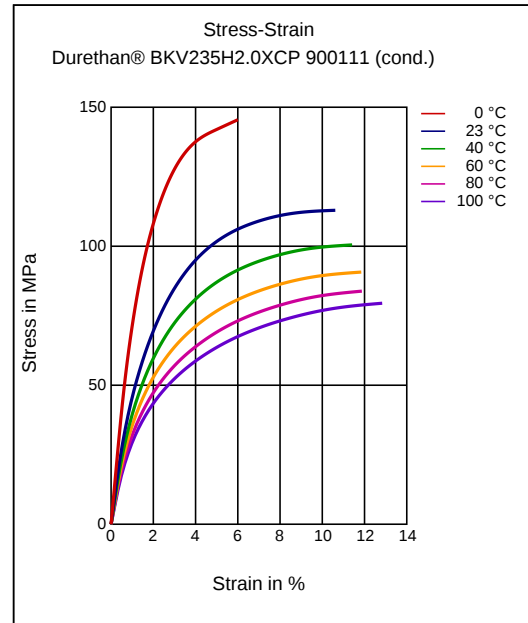
Envalior

Diagrams

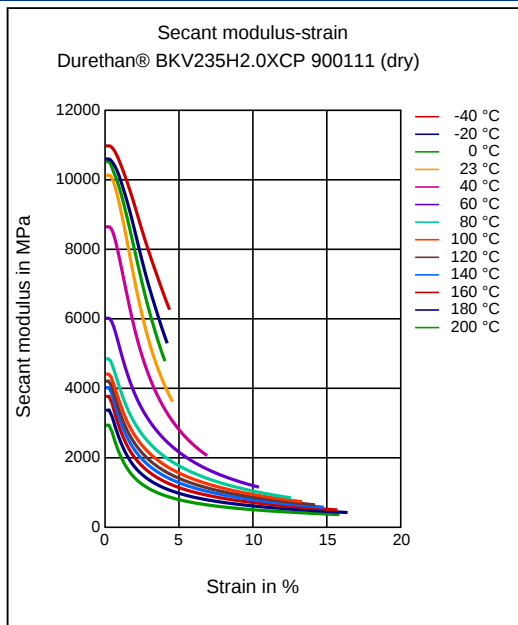
Stress-strain



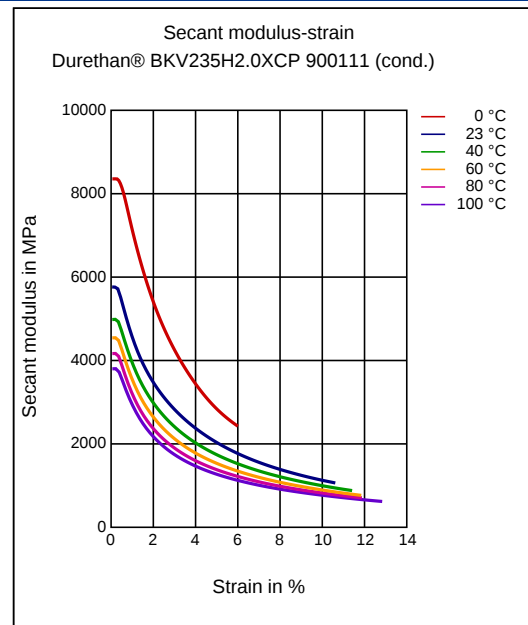
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Impact modified, Heat aging stabilized

Injection Molding

PREPROCESSING

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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): 280 - 300 °C

Mold temperature: 80 - 100 °C
