

Durethan® BKV240H2.0XCP 901510
PA6-I-GF40

Envalior

Injection Molding, 40% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA6-I-GF40

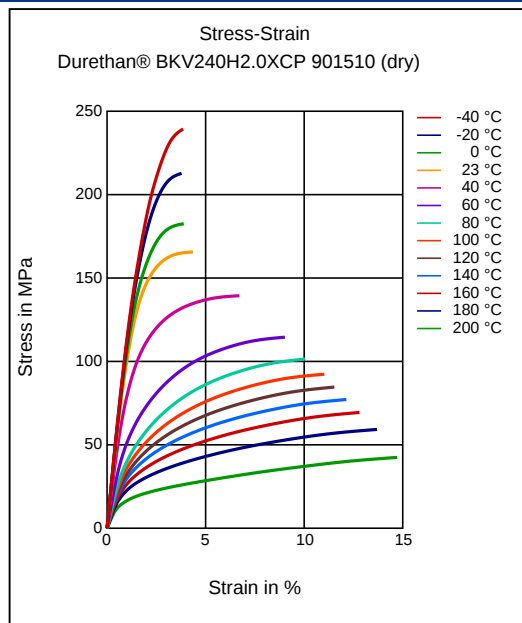
Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11000 / 6000	MPa	ISO 527
Stress at Break	160 / 100	MPa	ISO 527
Strain at Break	5.5 / 11	%	ISO 527
Impact Strength (Charpy), +23°C	110 / 125	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	105 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	30 / 50	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	17 / -	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1450 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	1100 / -	N	ISO 6603-2
Puncture energy, +23°C	9.1 / -	J	ISO 6603-2
Puncture energy, -30°C	4.7 / -	J	ISO 6603-2
Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	203 / *	°C	ISO 75-1/-2
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1410 / -	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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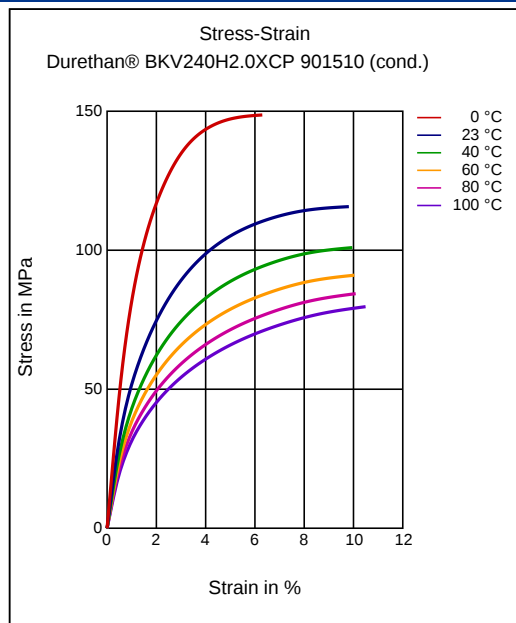
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Diagrams

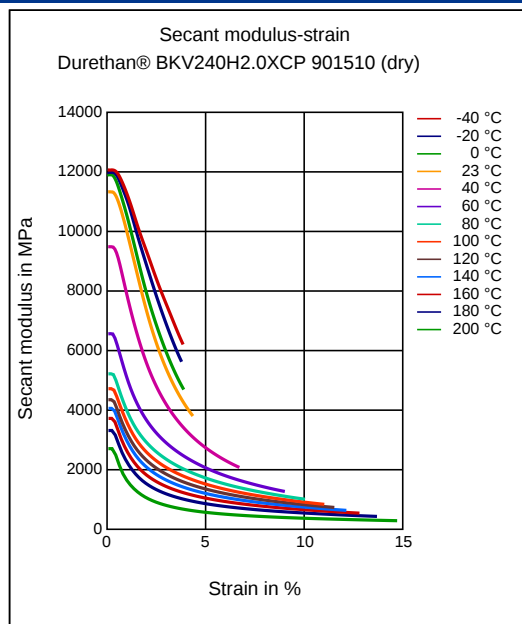
Stress-strain



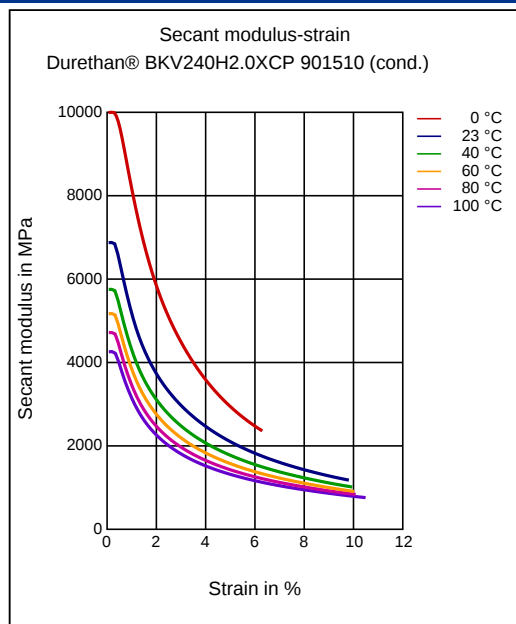
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Additives

Release agent

Special Characteristics

Impact modified, Heat aging stabilized

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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
