

Durethan® BKV115H2.0 000000 DUS008
PA6-I-GF15

Envalior

Injection Molding, 15% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA6-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			
ISO Data			
Tensile Modulus	5900 / 3000	MPa	ISO 527
Stress at Break	115 / 60	MPa	ISO 527
Strain at Break	4 / 12	%	ISO 527
Impact Strength (Charpy), +23°C	65 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	45 / 45	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	- / 15	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	- / 10	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	710 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	590 / -	N	ISO 6603-2
Puncture energy, +23°C	3 / -	J	ISO 6603-2
Puncture energy, -30°C	2.2 / -	J	ISO 6603-2
Flexural Modulus (23°C)	5200 / 2900	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / 15	kJ/m ²	ISO 180/1A
Notched Impact Strength (Izod)	10 / 10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	55 / 85	kJ/m ²	ISO 180/1U
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	221 / *	°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)	215 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Other Properties			
ISO Data			
Density	1230 / -	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
Value			
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	-

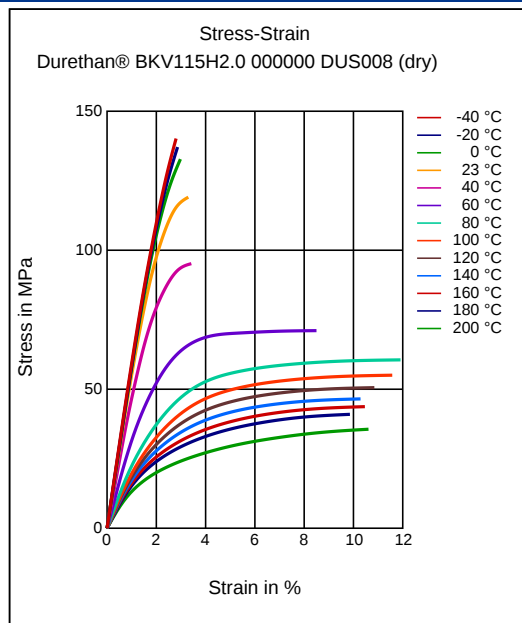
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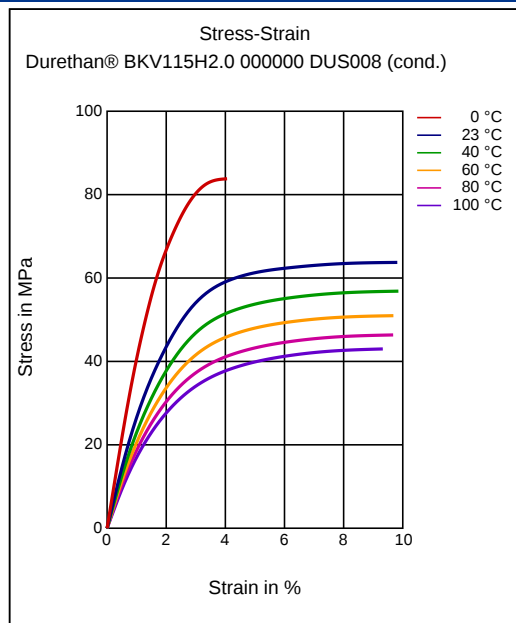
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Diagrams

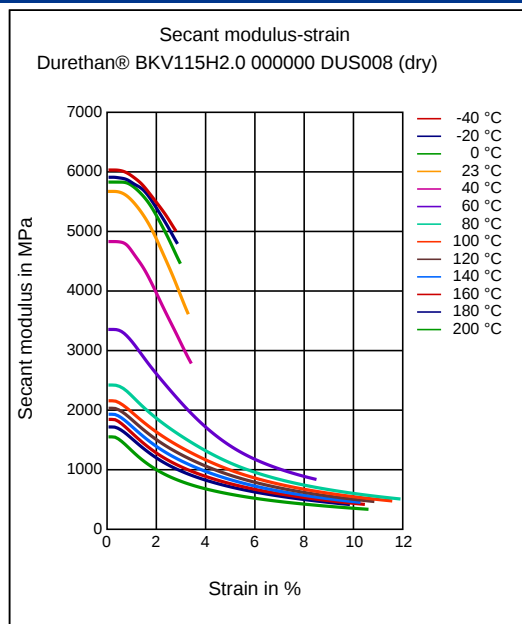
Stress-strain



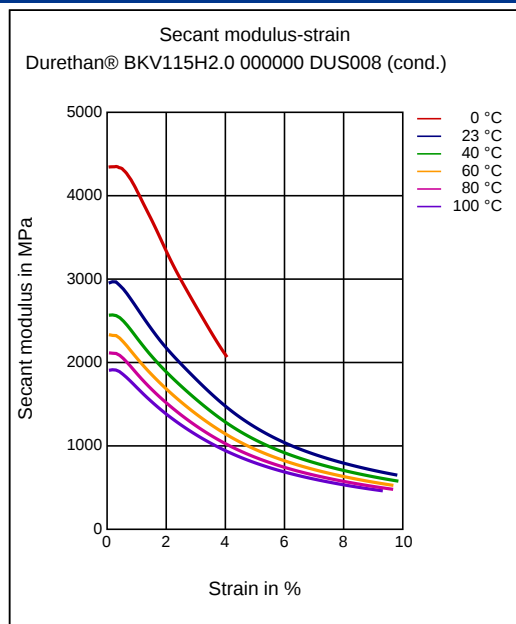
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

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): 260 - 290 °C

Mold temperature: 80 - 100 °C
