

Durethan® BKV230 000000 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	0.8 / *	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	8500 / 4200	MPa	ISO 527
Stress at Break	130 / 80	MPa	ISO 527
Strain at Break	4.1 / 8.6	%	ISO 527
Impact Strength (Charpy), +23°C	85 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	95 / 90	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 37	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	13 / 13	kJ/m ²	ISO 179/1eA
Flexural Modulus (23°C)	7400 / 4200	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	20 / 35	kJ/m ²	ISO 180/1A
Notched Impact Strength (Izod)	15 / 15	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	75 / 95	kJ/m ²	ISO 180/1U
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	198 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	218 / *	°C	ISO 75-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Other Properties			
ISO Data			
Density	1320 / -	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	-

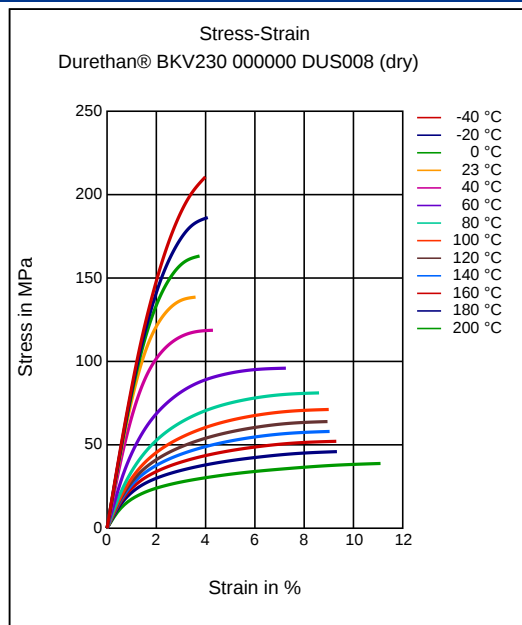
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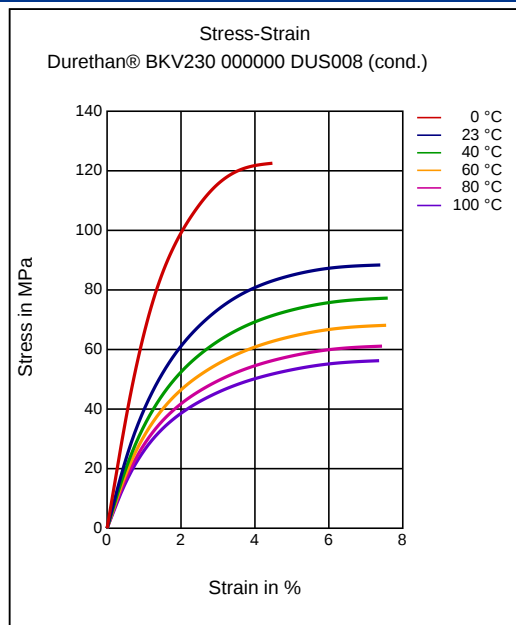
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Diagrams

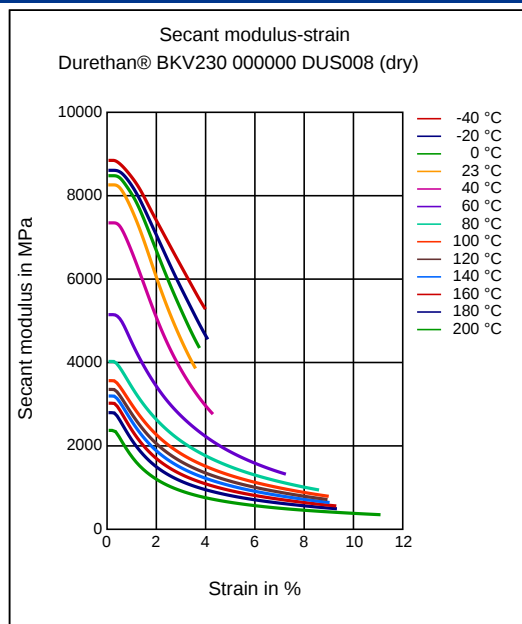
Stress-strain



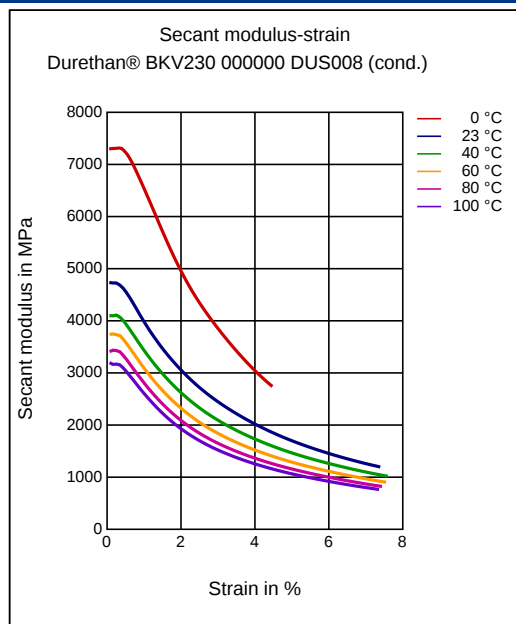
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Special Characteristics

Impact modified

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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
