

Durethan® BKV25F30 000000
PA6-GF25 FR(17)

Envalior

Injection Molding, 25% Glass Reinforced, Flame Retardant, Heat Stabilized

ISO 1043 PA6-GF25 FR(17)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11000 / 7300	MPa	ISO 527
Stress at Break	150 / 90	MPa	ISO 527
Strain at Break	2.3 / 4.4	%	ISO 527
Impact Strength (Charpy), +23°C	55 / 55	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	45 / 50	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10 / 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	1000 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	900 / -	N	ISO 6603-2
Puncture energy, +23°C	3 / -	J	ISO 6603-2
Puncture energy, -30°C	1.9 / -	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)	215 / *	°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	90 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.0 / *	mm	-

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Volume Resistivity	3.4E12 / -	Ohm*m	IEC 62631-3-1
Comparative tracking index	400 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	4.3 / *	%	Sim. to ISO 62
Humidity absorption	1.3 / *	%	Sim. to ISO 62
Density	1600 / -	kg/m ³	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

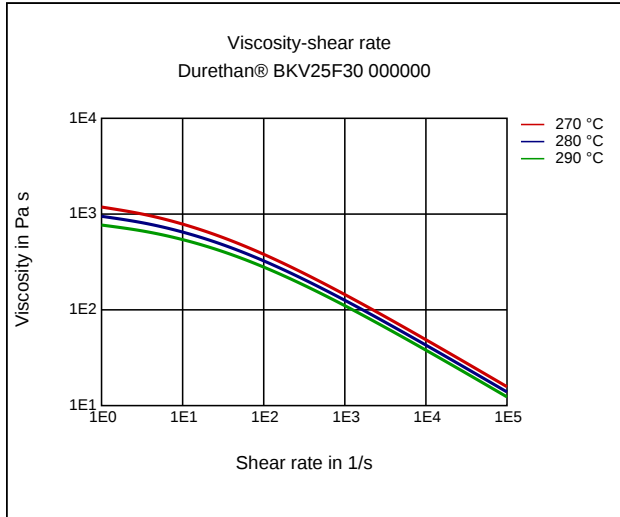
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 100	°C	-

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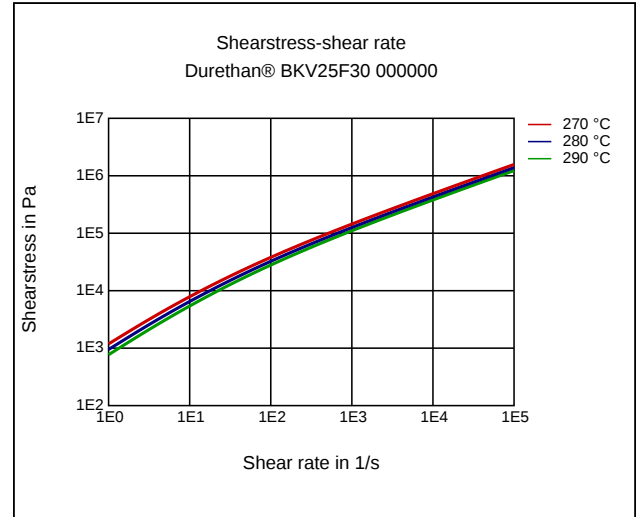
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Diagrams

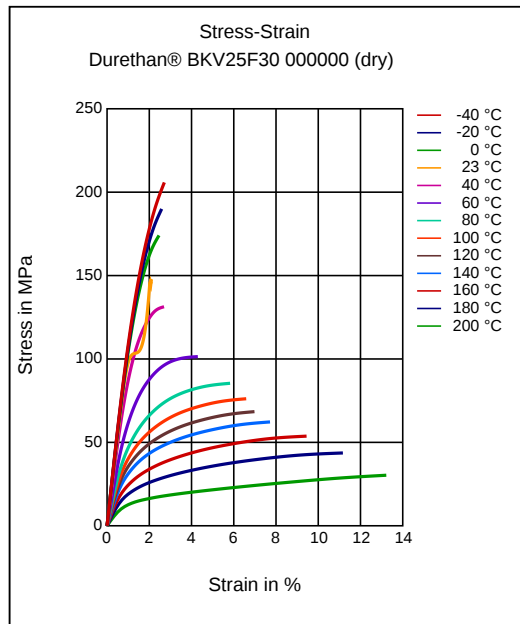
Viscosity-shear rate



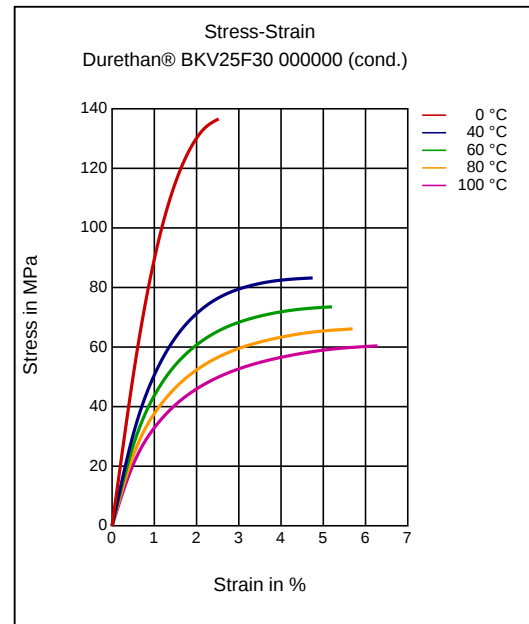
Shearstress-shear rate



Stress-strain



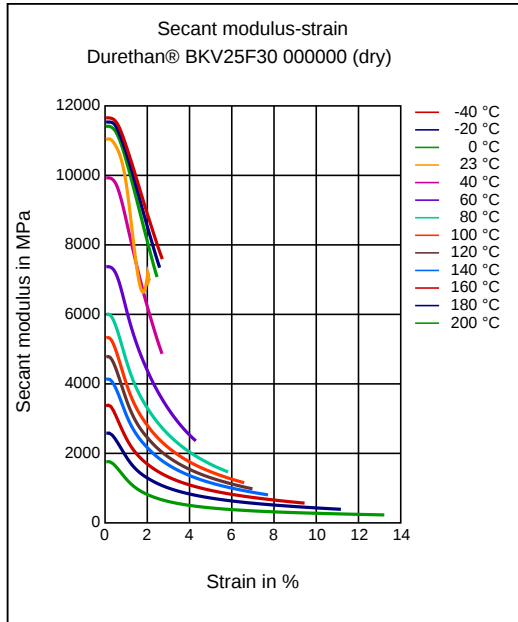
Stress-strain



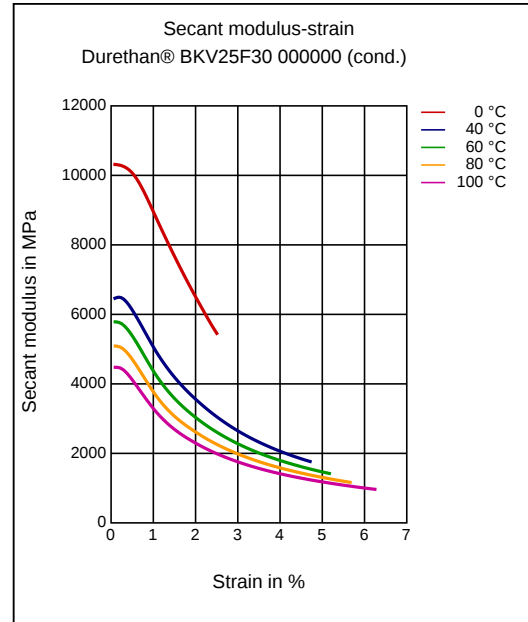
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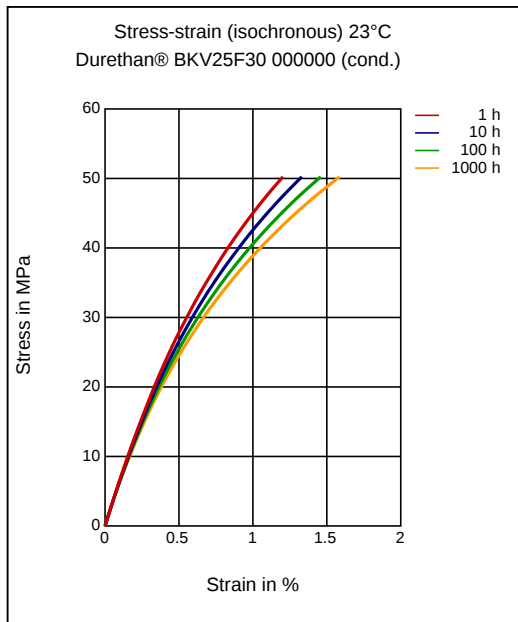
Secant modulus-strain



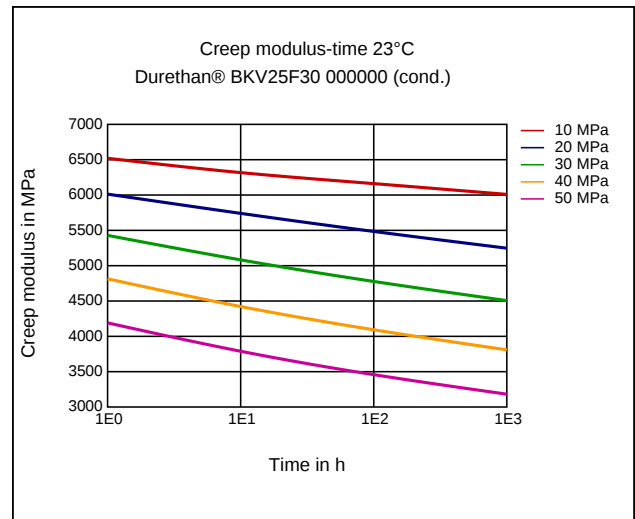
Secant modulus-strain



Stress-strain (isochronous) 23 °C



Creep modulus-time 23 °C



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

Special Characteristics

Flame retardant, Heat aging stabilized

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Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

Mold temperature: 80 - 100 °C
