

Durethan® BKV30GW1 901317
PA6-GF30

Envalior

Injection Molding, 30% Glass Reinforced

ISO 1043 PA6-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9900 / 6600	MPa	ISO 527
Stress at Break	180 / 106	MPa	ISO 527
Strain at Break	2.7 / 6.1	%	ISO 527
Impact Strength (Charpy), +23°C	60 / 65	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	50 / 40	kJ/m ²	ISO 179/1eU
Puncture - maximum force, +23°C	840 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	740 / -	N	ISO 6603-2
Puncture energy, +23°C	3 / -	J	ISO 6603-2
Puncture energy, -30°C	2 / -	J	ISO 6603-2
Flexural Modulus (23°C)	8700 / 6300	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	10 / 10	kJ/m ²	ISO 180/1A
Impact Strength (Izod), 23°C	50 / 60	kJ/m ²	ISO 180/1U
Ball Indentation Hardness	209 / -	MPa	ISO 2039-1

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	219 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	200 / *	°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	80 / *	E-6/K	ISO 11359-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	500 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	6.4 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1360 / -	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 - 120	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

UV stablized

Durethan® BKV30GW1 901317
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Delivery form

Pellets

Injection Molding

PREPROCESSING

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): 270 - 290 °C

Mold temperature: 80 - 120 °C
