

Durethan® BKV30 000000
PA6-GF30

Envalior

Injection Molding, 30% Glass Reinforced

ISO 1043 PA6-GF30

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	14 / *	cm ³ /10min	ISO 1133
Temperature	260 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9800 / 6100	MPa	ISO 527
Stress at Break	170 / 105	MPa	ISO 527
Strain at Break	3 / 6	%	ISO 527
Tensile Creep Modulus, 1h	* / 5100	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 4100	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	80 / 95	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	70 / 70	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	12 / 20	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	10 / 10	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1070 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	950 / -	N	ISO 6603-2
Puncture energy, +23°C	8 / 14	J	ISO 6603-2
Puncture energy, -30°C	6 / 5	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)	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	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	-
Oxygen index	22 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4 / 10	-	IEC 62631-2-1
Relative permittivity, 1MHz	4 / 5	-	IEC 62631-2-1
Dissipation Factor, 100Hz	50 / 2000	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	150 / 1200	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E12	Ohm	IEC 62631-3-2
Electric Strength	40 / 35	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	7 / *	%	Sim. to ISO 62
Humidity absorption	2.1 / *	%	Sim. to ISO 62
Density	1360 / -	kg/m ³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	140 / *	cm ³ /g	ISO 307, 1157, 1628

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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

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