

Durethan® BKV30XWPLT 904040
PA6-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Laser Weldable, Laser Transparent Black

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	0.3 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9500 / 7250	MPa	ISO 527
Stress at Break	175 / 120	MPa	ISO 527
Strain at Break	3.6 / 5.8	%	ISO 527
Puncture energy, +23°C	2.9 / 4.2	J	ISO 6603-2
Puncture energy, -30°C	3.1 / -	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)	188 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1360 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	125 / *	cm³/g	ISO 307, 1157, 1628

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

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Heat aging stabilized

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