

Durethan® BKV35XTS1 901510
PA6-GF35

Envalior

Injection Molding, 35% Glass Reinforced, Heat Stabilized

ISO 1043 PA6-GF35

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
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	10700 / 6500	MPa	ISO 527
Stress at Break	180 / 100	MPa	ISO 527
Strain at Break	3 / 5	%	ISO 527
Impact Strength (Charpy), +23°C	70 / 80	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	60 / 55	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	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	17 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1410 / -	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

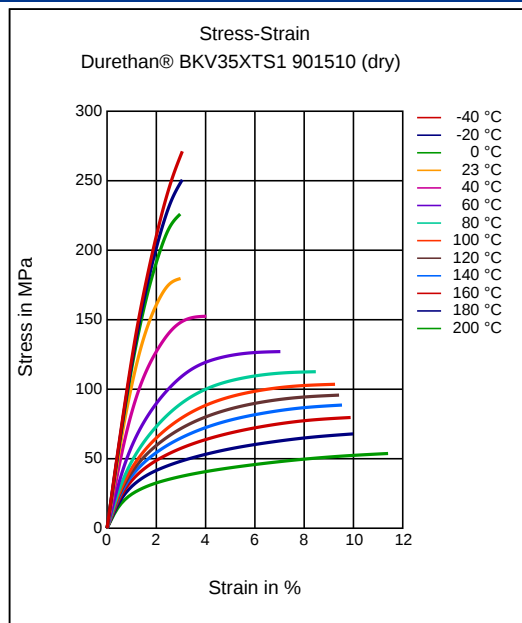
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 100	°C	-

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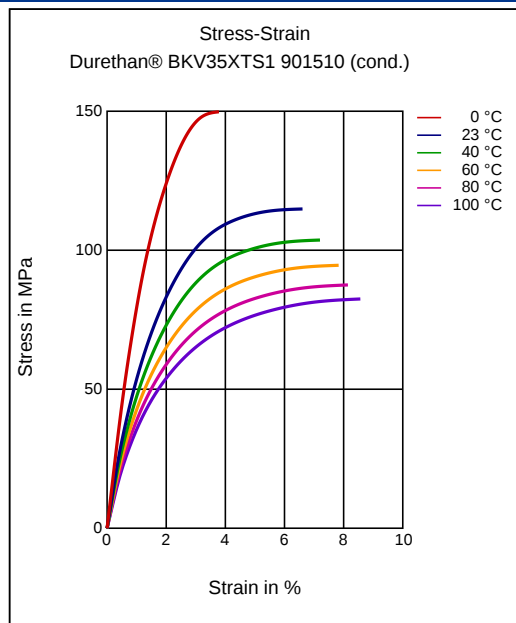
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Diagrams

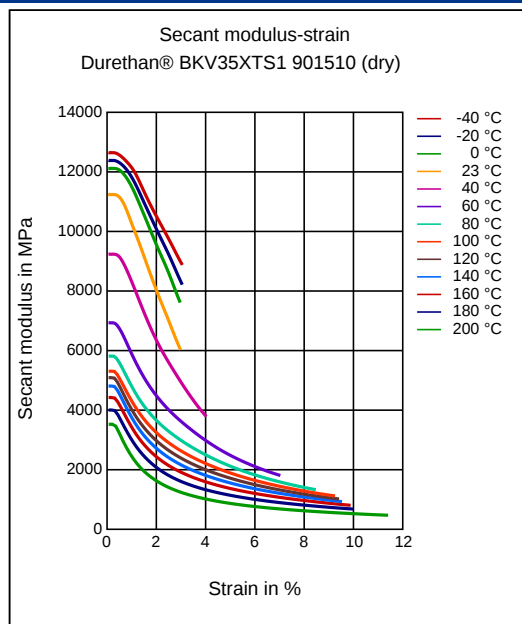
Stress-strain



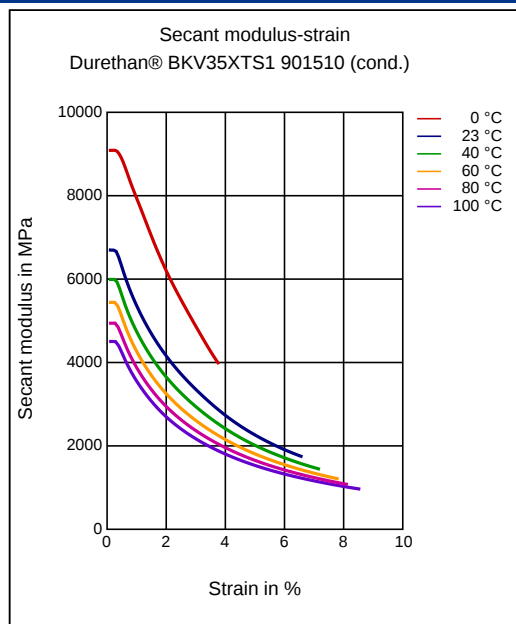
Stress-strain



Secant modulus-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Special Characteristics

Heat aging stabilized

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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): 270 - 290 °C
admissible residence time at Tmax <5 min
Mold temperature: 80 - 100 °C