

Durethan® DPBKV240H2.0
PA6-GF40

Envalior

PA 6-Copolymer, 40 % glass fibres, injection moulding, impact modified, heat-ageing stabilized

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10500 / 5700	MPa	ISO 527
Stress at Break	150 / 90	MPa	ISO 527
Strain at Break	4 / 7.5	%	ISO 527
Impact Strength (Charpy), +23°C	80 / 85	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	90 / 90	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	25 / 35	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	15 / 15	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	1250 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	1070 / -	N	ISO 6603-2
Puncture energy, +23°C	8 / -	J	ISO 6603-2
Puncture energy, -30°C	4.7 / -	J	ISO 6603-2

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	210 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	195 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	210 / *	°C	ISO 75-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1410 / -	kg/m³	ISO 1183

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	1200	kg/m³	-
Thermal Conductivity of Melt	0.225	W/(m K)	-
Spec. heat capacity of melt	2020	J/(kg K)	-
Eff. thermal diffusivity	1.03E-7	m²/s	-
Ejection temperature	140	°C	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Characteristics
Processing

Injection Molding

Special Characteristics

Impact modified, Heat aging stabilized

Delivery form

Pellets

Injection Molding

PREPROCESSING

Max. Water content: 0.1 %

Drying temperature: 80 °C

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Drying time:

Dry air dryer 2-20 h (will depend on the initial moisture content)

PROCESSING

Melt temperature: 270 - 290 °C

Mold temperature: 80 - 120 °C
