

Durethan® BKV 60 XF 900116

Polyamide 6

LANXESS GmbH

Message:

PA 6, 60 % glass fibers, injection molding, improved flowability, heat-aging stabilized

General Information				
Filler / Reinforcement		Glass Fiber,60% Filler by Weight		
Additive		Heat Stabilizer		
Features		Good Flow		
		Heat Stabilized		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.69	--	g/cm ³	ISO 1183
Apparent Density	0.76	--	g/cm ³	ISO 60
Molding Shrinkage				ISO 2577
Across Flow : 280°C, 2.00 mm ¹	0.52	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.070	--	%	
Flow : 280°C, 2.00 mm ³	0.25	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.050	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	20200	13000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	215	140	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.3	2.8	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	18500	14000	MPa	ISO 178/A
Flexural Stress ⁶ (23°C)	350	230	MPa	ISO 178/A
Flexural Strain at Flexural Strength ⁷ (23°C)	2.6	2.8	%	ISO 178/A
ISO Shortname	PA 6, GHR, 10-220, GF60	--		ISO 1874
Residual Moisture Content	0.030 to 0.20		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	88	--	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	15	--	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U

-30°C	80	--	kJ/m²	
23°C	80	75	kJ/m²	
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	3.40	--	J	
23°C	4.20	--	J	
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	950	--	N	
23°C	1100	--	N	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	217	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	208	--	°C	ISO 75-2/A
Melting Temperature ⁸	221	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	1.1E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	8.5E-5	--	cm/cm/°C	
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer				
	80.0		°C	
Drying Time - Dry Air Dryer		2.0 to 6.0	hr	
Processing (Melt) Temp		270 to 290	°C	
Mold Temperature		80.0 to 120	°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 bar			
4.	60x60x2mm			
5.	2.0 mm/min			
6.	2.0 mm/min			
7.	2 mm/min			
8.	10°C/min			

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