

Durethan® BKV 240 H2.0 XCP 901510

Polyamide 6

LANXESS GmbH

Message:

PA 6, 40 % glass fibers, injection molding, impact modified, heat-aging stabilized

General Information				
Filler / Reinforcement		Glass Fiber,40% Filler by Weight		
Additive		Heat Stabilizer		
		Impact Modifier		
Features		Heat Stabilized		
		Impact Modified		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.41	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 280°C, 2.00 mm ¹	0.73	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.13	--	%	
Flow : 280°C, 2.00 mm ³	0.25	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.030	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	11000	6000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	160	100	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	5.5	11	%	ISO 527-2/5
Nominal Tensile Strain at Break (23°C)	--	10	%	ISO 527-2/50
Flexural Modulus ⁵ (23°C)	10100	6300	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain,23°C	235	125	MPa	
23°C ⁶	255	150	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	5.0	5.5	%	ISO 178/A
ISO Shortname	PA 6-HI,GHR,14-110,GF40	--		ISO 1874
Residual Moisture Content	0.030 to 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

-30°C	17	--	kJ/m ²	
23°C	28	40	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	110	--	kJ/m ²	
23°C	110	130	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
-30°C	17	--	kJ/m ²	
23°C	28	40	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	95	--	kJ/m ²	
23°C	95	110	kJ/m ²	
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	4.70	--	J	
23°C	9.10	--	J	
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	1100	--	N	
23°C	1450	--	N	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	203	--	°C	ISO 75-2/A
Melting Temperature ⁸	220	--	°C	ISO 11357-3
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	280 to 300		°C	
Mold Temperature	80.0 to 100		°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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