

Durethan® BKV 15 DUS008 000000

Polyamide 6

LANXESS GmbH

Message:

PA 6, 15 % glass fibers, injection molding

General Information				
UL YellowCard		E245249-100868026		
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction: 280°C, 2.00mm ¹	0.59	--	%	ISO 294-4
Vertical flow direction: 120°C, 2 hours, 2.00mm ²	0.16	--	%	ISO 294-4
Flow direction: 280°C, 2.00mm ³	0.35	--	%	ISO 294-4
Flow direction: 120°C, 2 hours, 2.00mm ⁴	0.13	--	%	ISO 294-4
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	6500	3100	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	130	65.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	12	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	5500	3100	MPa	ISO 178/A
Flexural Stress ⁶				
3.5% strain	180	80.0	MPa	ISO 178/A
23°C	205	110	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	5.3	8.0	%	
ISO Shortname	PA 6, GR, 14-060, GF15	--		ISO 1874
Films	Dry	Conditioned	Unit	Test Method
Film Puncture Force ⁸	940	--	N	ISO 6603-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	45	45	kJ/m ²	ISO 179/1eU
23°C	50	100	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	< 10	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U

-30°C	40	40	kJ/m ²	ISO 180/1U
23°C	45	85	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	215	--	°C	ISO 75-2/B
1.8 MPa, not annealed	195	--	°C	ISO 75-2/A
Vicat Softening Temperature	210	--	°C	ISO 306/B120
Melting Temperature ⁹	220	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	3.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	1.0E-4	--	cm/cm/°C	ISO 11359-2
Injection	Dry	Unit		
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 - 6.0		hr	
Processing (Melt) Temp	260 - 290		°C	
Mold Temperature	80.0 - 100		°C	
NOTE				
1.	60x60x2; MT 80°C; 600 Bar			
2.	60x60x2			
3.	60x60x2; MT 80°C; 600 Bar			
4.	60x60x2			
5.	2.0 mm/min			
6.	2.0 mm/min			
7.	Pull Rate: 2 mm/min; 50% RH			
8.	23°C			
9.	10°C/min			

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