

Durethan® BKV 130 CS DUS008 600091

Polyamide 6

LANXESS GmbH

Message:

PA 6, 30 % glass fibers, injection molding, improved impact strength

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Impact resistance, good		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.36	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction: 280°C, 2.00mm ¹	0.75	%	ISO 294-4
Vertical flow direction: 120°C, 2 hours, 2.00mm ²	0.090	%	ISO 294-4
Flow direction: 280°C, 2.00mm ³	0.25	%	ISO 294-4
Flow direction: 120°C, 2 hours, 2.00mm ⁴	0.050	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9200	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	145	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.5	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	8500	MPa	ISO 178/A
Flexural Stress ⁶ (23°C)	245	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	3.3	%	
ISO Shortname	PA 6-HI, GR, 14-100, GF30		ISO 1874
Residual Moisture Content	0.030 - 0.12	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	< 10	kJ/m ²	ISO 179/1eA
23°C	< 10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	55	kJ/m ²	ISO 179/1eU
23°C	75	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	< 10	kJ/m ²	ISO 180/1A
23°C	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	60	kJ/m ²	ISO 180/1U
23°C	65	kJ/m ²	ISO 180/1U

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	210	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°C	ISO 75-2/A
Melting Temperature ⁸	220	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 55°C	2.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	1.1E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	Test Method
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.	10°C/min		

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