

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, 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 2577
Across Flow : 280°C, 2.00 mm ¹	0.59	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.16	--	%	
Flow : 280°C, 2.00 mm ³	0.35	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.13	--	%	
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				ISO 178/A
3.5% Strain, 23°C	180	80.0	MPa	
23°C ⁶	205	110	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	5.3	8.0	%	ISO 178/A
ISO Shortname	PA 6, GR, 14-060, GF15	--		ISO 1874
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	45	45	kJ/m ²	
23°C	50	100	kJ/m ²	
Notched Izod Impact Strength (23°C)				ISO 180/1A
< 10		10	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	40	40	kJ/m ²	
23°C	45	85	kJ/m ²	

Multi-Axial Instrumented Impact Peak Force (23°C)	940	--	N	ISO 6603-2
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	215	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	195	--	°C	ISO 75-2/A
Vicat Softening Temperature	210	--	°C	ISO 306/B120
Melting Temperature ⁸	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	3.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	1.0E-4	--	cm/cm/°C	
Injection	Dry	Unit		
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 to 6.0		hr	
Processing (Melt) Temp	260 to 290		°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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