

Durethan® BKV 60 EF DUS097 000000

Polyamide 6

LANXESS Asia/Pacific

Message:

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

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 60% filler by weight		
Additive		heat stabilizer		
Features		Good liquidity		
		Thermal Stability		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Molding Shrinkage				ISO 2577
Vertical flow direction: 280°C, 2.00mm ¹	0.60	--	%	ISO 2577
Vertical flow direction: 120°C, 4 hours, 2.00mm ²	0.020	--	%	ISO 2577
Flow direction: 280°C, 2.00mm ³	0.30	--	%	ISO 2577
Flow direction: 120°C, 4 hours, 2.00mm ⁴	0.030	--	%	ISO 2577
Water Absorption				ISO 62
Saturated, 23°C	3.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	19400	12500	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	230	158	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	3.5	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	20000	13600	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% strain, 23°C	--	250	MPa	ISO 178/A
23°C ⁶	390	260	MPa	ISO 178/A
Flexural Strain at Flexural Strength ⁷ (23°C)	3.0	4.0	%	ISO 178/A
ISO Shortname	PA 6, GHR, 10-190, GF60	--		ISO 1874
Residual Moisture Content	0.060 - 0.20		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

-30°C	17	--	kJ/m ²	ISO 179/1eA
23°C	17	24	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	95	95	kJ/m ²	ISO 179/1eU
Notched Izod Impact				ISO 180/1A
-30°C	18	--	kJ/m ²	ISO 180/1A
23°C	18	29	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	95	95	kJ/m ²	ISO 180/1U
23°C	90	90	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	3.80	--	J	ISO 6603-2
23°C	4.30	--	J	ISO 6603-2
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	1350	--	N	ISO 6603-2
23°C	1480	--	N	ISO 6603-2
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	220	--	°C	ISO 75-2/B
1.8 MPa, not annealed	213	--	°C	ISO 75-2/A
8.0 MPa, not annealed	186	--	°C	ISO 75-2/C
Melting Temperature ⁸	221	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	1.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	8.0E-5	--	cm/cm/°C	ISO 11359-2
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 - 6.0		hr	
Processing (Melt) Temp	270 - 290		°C	
Mold Temperature	80.0 - 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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