

Durethan® BC 30 S 000000

Polyamide 6

LANXESS GmbH

Message:

PA 6, non-reinforced, injection molding

General Information				
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.12	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 270°C, 2.00 mm ¹	0.90	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.30	--	%	
Flow : 270°C, 2.00 mm ³	1.0	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.30	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3200	1000	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	80.0	45.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	4.0	24	%	ISO 527-2/50
Flexural Modulus ⁵ (23°C)	2800	1000	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain, 23°C	90.0	30.0	MPa	
23°C ⁶	105	40.0	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	6.0	7.0	%	ISO 178/A
ISO Shortname	PA 6, GR, 14-030	--		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	< 10	< 10	kJ/m ²	
23°C	< 10	30	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)				ISO 179/1eU
No Break				
Notched Izod Impact Strength				ISO 180/1A
-30°C	< 10	< 10	kJ/m ²	
23°C	< 10	20	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U

-30°C	200	--	kJ/m²	
23°C	No Break	No Break		
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	25.0	--	J	
23°C	55.0	--	J	
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	4400	--	N	
23°C	5000	--	N	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	172	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	66.0	--	°C	ISO 75-2/A
Melting Temperature ⁸	221	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	1.0E-4	--	cm/cm/°C	
Transverse : 23 to 55°C	8.0E-5	--	cm/cm/°C	
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer				
	80.0		°C	
Drying Time - Dry Air Dryer			hr	
Processing (Melt) Temp		260 to 280	°C	
Mold Temperature		80.0 to 90.0	°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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