

**Product Texts**

PA 6-Copolymer, 15 % glass fibres, injection moulding, impact modified

**Processing/Physical Characteristics**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	28 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	260 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5 / *	%	ISO 294-4, 2577
Density of melt	1050	kg/m <sup>3</sup>	-
Thermal conductivity of melt	0.199	W/(m K)	-
Spec. heat capacity of melt	2400	J/(kg K)	-
Eff. thermal diffusivity	7.92E-8	m <sup>2</sup> /s	-
Ejection temperature	140	°C	-

**Mechanical properties**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	5700 / 2800	MPa	ISO 527
Stress at break	120 / 65	MPa	ISO 527
Strain at break	4 / 12	%	ISO 527
Tensile creep modulus, 1h	* / 2600	MPa	ISO 899-1
Tensile creep modulus, 1000h	* / 2000	MPa	ISO 899-1
Charpy impact strength, +23°C	65 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	45 / 40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	10 / 20	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / 10	kJ/m <sup>2</sup>	ISO 179/1eA
Puncture - maximum force, +23°C	737 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	636 / -	N	ISO 6603-2
Puncture energy, +23°C	2.9 / -	J	ISO 6603-2
Puncture energy, -30°C	2.2 / 2.2	J	ISO 6603-2

**Thermal properties**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	213 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	205 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	200 / *	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Oxygen index	22 / *	%	ISO 4589-1/-2

**Electrical properties**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Relative permittivity, 100Hz	4.1 / 8	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.7 / 4.8	-	IEC 62631-2-1
Dissipation factor, 100Hz	80 / 2150	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200 / 1300	E-4	IEC 62631-2-1
Volume resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 1E13	Ohm	IEC 62631-3-2
Electric strength	35 / 35	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	-	IEC 60112

**Other properties**

	dry / cond	Unit	Test Standard
Water absorption	8.5 / *	%	Sim. to ISO 62
Humidity absorption	2.5 / *	%	Sim. to ISO 62
Density	1230 / -	kg/m <sup>3</sup>	ISO 1183

**Durethan® BKV115**

PA6-GF15

Envalior

Material specific properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Viscosity number	134 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Additives**

Release agent

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

**Other text information****Injection Molding**

## PREPROCESSING

Max. Water content: 0.1 %

Drying temperature: 80 °C

Drying time:

Dry air dryer 2-20 h (will depend on the initial moisture content)

## PROCESSING

Melt temperature: 270 - 290 °C

Mold temperature: 80 - 120 °C