

**Product Texts**

Injection Molding, 25% Glass Beads Reinforced, Flame Retardant (halogen free), Heat Stabilized

ISO 1043 PA6-GX25 FR(40+30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	5700 / 2500	MPa	ISO 527
<sup>[C]</sup> Stress at break	80 / 40	MPa	ISO 527
<sup>[C]</sup> Strain at break	3 / 20	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	35 / 55	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	23 / 25	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	170 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	50 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	80 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn. Thickness tested	V-2 / * 1.5 / *	class mm	IEC 60695-11-10 -
<sup>[C]</sup> Oxygen index	25 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Electric strength	32 / -	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	525 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	6.3 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	2 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1350 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-

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PA6-GF25 FR(40+30)

Envalior

Melt temperature	<b>250 - 270</b>	°C	-
Mold temperature	<b>80 - 100</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Flame retardant, Halogen-free, Heat stabilized or stable to heat

**Delivery form**

Pellets

**Regional Availability**

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

**Other text information****Injection molding**

## PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

## PROCESSING

Melt temperature (Tmin - Tmax): 250 - 270 °C

Mold temperature: 80 - 100 °C