# Durethan® BKV115 000000 DUS008

PA6-I-GF15 Envalior

## Product Texts

Injection Molding, 15% Glass Reinforced, Improved Impact

ISO 1043 PA6-I-GF15

| Mechanical properties | dry / cond | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| [C] Tensile Modulus | **5600 / 2800** | MPa | ISO 527 |
| [C] Stress at break | **115 / 65** | MPa | ISO 527 |
| [C] Strain at break | **4 / 12** | % | ISO 527 |
| [C] Charpy impact strength, +23°C | **65 / 80** | kJ/m² | ISO 179/1eU |
| [C] Charpy impact strength, -30°C | **50 / -** | kJ/m² | ISO 179/1eU |
| [C] Charpy notched impact strength, +23°C | **- / 15** | kJ/m² | ISO 179/1eA |
| [C] Charpy notched impact strength, -30°C | **- / 10** | kJ/m² | ISO 179/1eA |

[C]: CAMPUS

| Thermal properties | dry / cond | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| [C] Melting temperature, 10°C/min | **220 / *** | °C | ISO 11357-1/-3 |
| [C] Temp. of deflection under load, 1.80 MPa | **195 / *** | °C | ISO 75-1/-2 |
| [C] Temp. of deflection under load, 0.45 MPa | **215 / *** | °C | ISO 75-1/-2 |
| [C] Burning rate, FMVSS, Thickness 1 mm | **71.3** | mm/min | ISO 3795 (FMVSS 302) |

[C]: CAMPUS

| Other properties | dry / cond | Unit | Test Standard |
|---|---|---|---|
| [C] Density | **1230 / -** | kg/m³ | ISO 1183 |

[C]: CAMPUS

| Test specimen production | Value | Unit | Test Standard |
|---|---|---|---|
| **ISO Data** | | | |
| [C] Injection Molding, melt temperature | **280** | °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 | **≤0.12** | % | - |
| Melt temperature | **260 - 290** | °C | - |
| Mold temperature | **80 - 100** | °C | - |

## Characteristics

**Processing**
Injection Molding

**Special Characteristics**
High impact or impact modified

**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 - 0.12%
Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING
Melt temperature (Tmin - Tmax): 260 - 290 °C

Mold temperature: 80 - 100 °C