

Durethan BKV35Z 901510

PA 6-Copolymer, 35 % glass fibers, injection molding

ISO Shortname: ISO 16396-PA 6/66,GF35,GR,S14-100

Property	Test Condition	Unit	Standard	guide value d.a.m.	cond.
Rheological properties					
Molding shrinkage, parallel	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 2577	0.15	
Molding shrinkage, transverse	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 2577	0.78	
Post- shrinkage, parallel	150x105x3; 120 °C; 4 h	%	acc. ISO 2577	0.04	
Post- shrinkage, transverse	150x105x3; 120 °C; 4 h	%	acc. ISO 2577	0.13	
Mechanical properties (23 °C/50 % r. h.)					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	10000	6200
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	185	120
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	2.7	6.5
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	75	75
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179-1eA	<10	10
C Charpy notched impact strength	-30 °C	kJ/m ²	ISO 179-1eA	<10	10
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-1A	<10	15
Flexural modulus	2 mm/min	MPa	ISO 178-A	9300	5900
Flexural strength	2 mm/min	MPa	ISO 178-A	290	175
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	4	6
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	280	150
Thermal properties					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	213	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	180	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	210	
Other properties (23 °C)					
C Density		kg/m ³	ISO 1183	1410	
Bulk density		kg/m ³	ISO 60	700	
Processing conditions for test specimens					
C Injection molding-Melt temperature		°C	ISO 294	280	
C Injection molding-Mold temperature		°C	ISO 294	80	
Processing recommendations					
Drying temperature dry air dryer		°C	-	80	
Drying time dry air dryer		h	-	2-6	
Residual moisture content		%	Acc. to Karl Fischer	0.03-0.12	
Melt temperature (Tmin - Tmax)		°C	-	270-290	
Mold temperature		°C	-	80-120	

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.



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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

Conditioning

Conditioning in accordance with ISO 1110 (70 °C; 62 % r.h.)

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