

Durethan® BKV 115 H2.0 DUS008 000000

Polyamide 6

LANXESS GmbH

Message:

PA 6, 15% glass fibers, injection molding, improved impact strength, heat-aging stabilized

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	heat stabilizer		
Features	Impact resistance, good		
	Good heat aging resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.23	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction: 280°C, 2.00mm ¹	0.60	%	ISO 294-4
Vertical flow direction: 120°C, 2 hours, 2.00mm ²	0.20	%	ISO 294-4
Flow direction: 280°C, 2.00mm ³	0.50	%	ISO 294-4
Flow direction: 120°C, 2 hours, 2.00mm ⁴	0.10	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	5900	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	114	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.1	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	5100	MPa	ISO 178/A
Flexural Stress ⁶			
3.5% strain	155	MPa	ISO 178/A
23°C	175	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	5.6	%	
ISO Shortname	PA 6-HI, GHR, 14-060, GF15		ISO 1874
Residual Moisture Content	0.030 - 0.12	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-40°C	< 10	kJ/m ²	ISO 179/1eA
-30°C	< 10	kJ/m ²	ISO 179/1eA
23°C	< 10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	45	kJ/m ²	ISO 179/1eU
23°C	65	kJ/m ²	ISO 179/1eU

Notched Izod Impact			ISO 180/1A
-30°C	< 10	kJ/m ²	ISO 180/1A
23°C	< 10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	35	kJ/m ²	ISO 180/1U
23°C	55	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	214	°C	ISO 75-2/B
1.8 MPa, not annealed	188	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 55°C	3.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	1.0E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	Test Method
Drying Temperature - Dry Air Dryer	80.0	°C	
Drying Time - Dry Air Dryer	2.0 - 6.0	hr	
Processing (Melt) Temp	260 - 290	°C	
Mold Temperature	80.0 - 100	°C	
NOTE			
1.	60x60x2; MT 80°C; 600 Bar		
2.	60x60x2		
3.	60x60x2; MT 80°C; 600 Bar		
4.	60x60x2		
5.	2.0 mm/min		
6.	2.0 mm/min		
7.	Pull Rate: 2 mm/min; 50% RH		

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