

Durethan® BKV 130 GIT DUS008 900116

Polyamide 6

LANXESS Corporation

Message:

PA 6, 30 % glass fibers, injection molding, improved impact strength, GIT/WIT

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Features		Good Impact Resistance		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 280°C, 2.00 mm ¹	0.50	--	%	
Across Flow : 120°C, 2 hr, 2.00 mm ²	0.15	--	%	
Flow : 280°C, 2.00 mm ³	0.20	--	%	
Flow : 120°C, 2 hr, 2.00 mm ⁴	0.060	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	9000	5000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	160	95.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.4	7.5	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	8500	4900	MPa	ISO 178/A
Flexural Stress ⁶				
3.5% Strain	230	122	MPa	ISO 178/A
23°C	256	145	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	4.1	6.3	%	
ISO Shortname	PA 6-HI, GR, 14-090, GF30	--		ISO 1874
Residual Moisture Content	0.030 to 0.12		%	Karl Fisher
Films	Dry	Conditioned	Unit	Test Method
Film Puncture Energy				ISO 6603-2
-- ⁸	2.50	--	J	
-- ⁹	3.80	--	J	
Film Puncture Force				ISO 6603-2
-- ¹⁰	770	--	N	
-- ¹¹	935	--	N	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

-30°C	10	10	kJ/m ²	
23°C	15	20	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	65	60	kJ/m ²	
23°C	85	85	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
-30°C	10	10	kJ/m ²	
23°C	15	15	kJ/m ²	
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	60	55	kJ/m ²	
23°C	75	60	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	210	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	195	--	°C	ISO 75-2/A
Vicat Softening Temperature	200	--	°C	ISO 306/B120
Melting Temperature ¹²	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	2.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	9.0E-5	--	cm/cm/°C	
Injection	Dry	Unit	Test Method	
Drying Temperature - Dry Air Dryer	80.0		°C	
Drying Time - Dry Air Dryer	2.0 to 6.0		hr	
Processing (Melt) Temp	260 to 290		°C	
Mold Temperature	80.0 to 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			
8.	-30°C			
9.	23°C			
10.	-30°C			
11.	23°C			

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