

Durethan® BKV 115 DUS008 000000

Polyamide 6

LANXESS Corporation

Message:

PA 6, 15% glass fibers, injection molding, improved impact strength

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Features		Impact resistance, good		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.23	--	g/cm ³	ISO 1183
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	5600	2800	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	115	65.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.0	12	%	ISO 527-2/5
Flexural Modulus ¹ (23°C)	4900	2500	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% strain, 23°C	165	70.0	MPa	ISO 178/A
23°C ²	185	95.0	MPa	ISO 178/A
Flexural Strain at Flexural Strength ³ (23°C)	5.0	8.0	%	ISO 178/A
ISO Shortname	PA 6-HI, GR, 14-060, GF15	--		ISO 1874
Admissible Residence Time at Tmax	1.3 - 1.7		hr	
Residual Moisture Content	0.030 - 0.12		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				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	50	--	kJ/m ²	ISO 179/1eU
23°C	65	80	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	215	--	°C	ISO 75-2/B
1.8 MPa, not annealed	195	--	°C	ISO 75-2/A
Melting Temperature ⁴	220	--	°C	ISO 11357-3
Injection	Dry	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

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	2 mm/min	
4.	10°C/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

