

Durethan® BKV 140 DUS008 000000

Polyamide 6

LANXESS GmbH

Message:

PA 6, 40 % glass fibers, injection molding, improved impact strength

General Information			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Features	Good Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Molding Shrinkage			ISO 2577
Across Flow : 280°C, 2.00 mm ¹	0.75	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.090	%	
Flow : 280°C, 2.00 mm ³	0.21	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.070	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	12000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	185	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.4	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	11000	MPa	ISO 178/A
Flexural Stress			ISO 178/A
3.5% Strain,23°C	280	MPa	
23°C ⁶	290	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	4.2	%	ISO 178/A
ISO Shortname	PA 6HI, GR, 14-120, GF40		ISO 1874
Residual Moisture Content	0.030 to 0.12	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	
23°C	15	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	100	kJ/m ²	
23°C	110	kJ/m ²	
Notched Izod Impact Strength (23°C)	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	90	kJ/m ²	
23°C	90	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, Unannealed	217	°C	ISO 75-2/B
1.8 MPa, Unannealed	201	°C	ISO 75-2/A
Melting Temperature ⁸	220	°C	ISO 11357-3
Injection	Nominal Value	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

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|----|-----------------------------|
| 1. | 60x60x2mm, 80°C MT, 400 bar |
| 2. | 60x60x2mm |
| 3. | 60x60x2mm, 80°C MT, 400 bar |
| 4. | 60x60x2mm |
| 5. | 2.0 mm/min |
| 6. | 2.0 mm/min |
| 7. | 2 mm/min |
| 8. | 10°C/min |

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