

Durethan® BKV 15 H2.0 DUS008 901510

Polyamide 6

LANXESS Corporation

Message:

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

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight		
Additive		Heat Stabilizer		
Features		Good Heat Aging Resistance		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 280°C, 2.00 mm ¹	0.80	--	%	
Across Flow : 120°C, 2 hr, 2.00 mm ²	0.20	--	%	
Flow : 280°C, 2.00 mm ³	0.50	--	%	
Flow : 120°C, 2 hr, 2.00 mm ⁴	0.10	--	%	
Water Absorption				ISO 62
Saturation, 23°C	8.5	--	%	
Equilibrium, 23°C, 50% RH	2.6	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	6600	3100	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	120	59.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.4	12	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	5700	2800	MPa	ISO 178/A
Flexural Stress ⁶				
3.5% Strain	175	75.0	MPa	ISO 178/A
23°C	195	100	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	4.8	7.3	%	
ISO Shortname	PA 6, GHR, 14-070, GF15	--		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	2.00	--	J	
-- ⁹	2.20	--	J	
Film Puncture Force				ISO 6603-2

-- 10	546	--	N	
-- 11	574	--	N	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	< 10	< 10	kJ/m ²	
23°C	< 10	< 10	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)	35	100	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	< 10	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	35	40	kJ/m ²	
23°C	40	90	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	216	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	190	--	°C	ISO 75-2/A
Melting Temperature ¹²	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	3.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	1.0E-4	--	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			
12.	10°C/min			

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