

Durethan® BKV 25 FN27 000000

Polyamide 6
LANXESS GmbH

Message:
PA 6, 25 % glass, injection molding, halogen free flame retardant

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Flame Retardant		
Features		Flame Retardant		
		Halogen Free		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.35	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 2577
Across Flow : 260°C, 2.00 mm ¹	0.70	--	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.20	--	%	
Flow : 260°C, 2.00 mm ³	0.60	--	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.20	--	%	
Water Absorption				ISO 62
Saturation, 23°C	7.0	--	%	
Equilibrium, 23°C, 50% RH	2.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	5300	2200	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	85.0	38.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	30	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	5000	3000	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% Strain,23°C	125	65.0	MPa	
23°C ⁶	135	70.0	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	4.0	6.5	%	ISO 178/A
ISO Shortname	PA6, GFHR, 12-050, G25, ISO1043, PA G FR (30)			ISO 1874
Residual Moisture Content	0.030 to 0.070		%	Karl Fisher
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	35	70	kJ/m ²	ISO 179/1eU

Unnotched Izod Impact Strength (23°C)	25	55	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	205	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	155	--	°C	ISO 75-2/A
Melting Temperature ⁸	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 1	--		UL 746
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.750 mm	V-2	--		
1.50 mm	V-2	--		
3.00 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	960	--	°C	
1.50 mm	960	--	°C	
3.00 mm	960	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.750 mm	750	--	°C	
1.50 mm	750	--	°C	
3.00 mm	750	--	°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	250 to 270		°C	
Mold Temperature	80.0 to 100		°C	
NOTE				
1.	60x60x2mm, 80°C MT, 600 bar			
2.	60x60x2mm			
3.	60x60x2mm, 80°C MT, 600 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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