

Durethan® BKV 215 H2.0 DUS035 900051

Polyamide 66/6 Copolymer

LANXESS GmbH

Message:

PA 6-Copolymer, 15 % glass fibers, injection molding, improved impact strength, heat-aging stabilized

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Additive		heat stabilizer		
Features		Low warpage		
		Copolymer		
		Good liquidity		
		Thermal Stability		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.17	--	g/cm ³	ISO 1183
Apparent Density	0.60	--	g/cm ³	ISO 60
Molding Shrinkage				ISO 2577
Vertical flow direction: 280°C, 2.00mm ¹	0.80	--	%	ISO 2577
Vertical flow direction: 120°C, 4 hours, 2.00mm ²	0.10	--	%	ISO 2577
Flow direction: 280°C, 2.00mm ³	0.50	--	%	ISO 2577
Flow direction: 120°C, 4 hours, 2.00mm ⁴	0.10	--	%	ISO 2577
Water Absorption				ISO 62
Saturated, 23°C	7.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.0	--	%	ISO 62
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness	120	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	4300	2100	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	85.0	55.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.5	15	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	4000	2000	MPa	ISO 178/A
Flexural Stress				ISO 178/A
3.5% strain, 23°C	120	55.0	MPa	ISO 178/A
23°C ⁶	135	70.0	MPa	ISO 178/A

Flexural Strain at Flexural Strength ⁷ (23°C)	5.5	8.0	%	ISO 178/A
ISO Shortname	PA 6/66-HI, GHR, 14-040, GF15--			ISO 1874
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	10	kJ/m ²	ISO 179/1eA
23°C	20	35	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	80	80	kJ/m ²	ISO 179/1eU
23°C	70	110	kJ/m ²	ISO 179/1eU
Notched Izod Impact				ISO 180/1A
-30°C	10	10	kJ/m ²	ISO 180/1A
23°C	20	35	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength				ISO 180/1U
-30°C	65	60	kJ/m ²	ISO 180/1U
23°C	60	90	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy				ISO 6603-2
-30°C	4.00	--	J	ISO 6603-2
23°C	10.0	--	J	ISO 6603-2
Multi-Axial Instrumented Impact Peak Force				ISO 6603-2
-30°C	750	--	N	ISO 6603-2
23°C	1500	--	N	ISO 6603-2
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	200	--	°C	ISO 75-2/B
1.8 MPa, not annealed	175	--	°C	ISO 75-2/A
Vicat Softening Temperature	200	--	°C	ISO 306/B120
Melting Temperature ⁸	214	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	4.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	1.5E-4	--	cm/cm/°C	ISO 11359-2
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

Mold Temperature	80.0 - 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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