

# Durethan BKV235H2.0XCP 900111

PA 6, 35 % glass fibers, injection molding, improved impact strength, heat-aging stabilized

ISO Shortname: ISO 16396-PA 6-I,GF35,GHR,S14-100

Property	Test Condition	Unit	Standard	guide value d.a.m. cond.	
<b>Rheological properties</b>					
C Molding shrinkage, parallel	60x60x2; 290 °C / MT 80 °C; 600 bar	%	ISO 294-4	0.25	
C Molding shrinkage, transverse	60x60x2; 290 °C / MT 80 °C; 600 bar	%	ISO 294-4	0.65	
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.05	
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1	
<b>Mechanical properties (23 °C/50 % r. h.)</b>					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	9500	5700
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	165	110
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	5.5	11.5
C Charpy impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eU	110	125
C Charpy impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eU	120	110
C Charpy notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eA	28	40
C Charpy notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eA	18	17
Charpy notched impact strength	-40 °C	kJ/m <sup>2</sup>	ISO 179-1eA	17	17
Izod impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1U	90	90
Izod impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1U	95	90
Izod notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1A	27	42
Izod notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1A	18	20
Flexural modulus	2 mm/min	MPa	ISO 178-A	8900	5600
Flexural strength	2 mm/min	MPa	ISO 178-A	260	155
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	5	6.5
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	240	125
C Puncture maximum force	23 °C	N	ISO 6603-2	1530	1770
C Puncture maximum force	-30 °C	N	ISO 6603-2	1200	1240
C Puncture energy	23 °C	J	ISO 6603-2	9	12
C Puncture energy	-30 °C	J	ISO 6603-2	5	5.5
<b>Thermal properties</b>					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	221	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	203	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	220	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	0.15	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	1.2	
<b>Other properties (23 °C)</b>					
C Density		kg/m <sup>3</sup>	ISO 1183	1365	
<b>Processing conditions for test specimens</b>					
C Injection molding-Melt temperature		°C	ISO 294	290	
C Injection molding-Mold temperature		°C	ISO 294	80	
<b>Processing recommendations</b>					



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Property	Test Condition	Unit	Standard	guide value	
				d.a.m.	cond.
Drying temperature dry air dryer		°C	-	80	
Drying time dry air dryer		h	-	2-6	
Residual moisture content		%	Acc. to Karl Fischer	0.03-0.12	
Melt temperature (Tmin - Tmax)		°C	-	280-300	
Mold temperature		°C	-	80-100	

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.



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### Disclaimer

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#### Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

#### Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

#### Conditioning

Conditioning in accordance with ISO 1110 (70 °C; 62 % r.h.)

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