

# Durethan® BKV15 DUS008

## PA6–GF15

15% Glass Reinforced, Injection Molding

Print Date: 2024–12–03

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Molding shrinkage (parallel)	0.35 / *	%	ISO 294–4
Molding shrinkage (normal)	0.59 / *	%	ISO 294–4
<b>MECHANICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Tensile modulus	6500 / 3100	MPa	ISO 527–1/–2
Stress at break	130 / 65	MPa	ISO 527–1/–2
Strain at break	3 / 12	%	ISO 527–1/–2
Flexural modulus	5500 / 3100	MPa	ISO 178
Flexural strength	205 / 110	MPa	ISO 178
Charpy impact strength (+23°C)	50 / 100	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (–30°C)	45 / 45	kJ/m <sup>2</sup>	ISO 179/1eU
Izod notched impact strength (+23°C)	<10 / 10	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Melting temperature (10°C/min)	220 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	195 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75–1/–2
Coeff. of linear therm. expansion (parallel)	0.3 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	1 / *	E–4/°C	ISO 11359–1/–2
Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695–11–10
Thickness tested	1.5 / *	mm	IEC 60695–11–10
Burning Behav. at 3.0 mm nom. thickn.	HB / *	class	IEC 60695–11–10
Thickness tested	3 / *	mm	IEC 60695–11–10

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## Property Data

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Print Date: 2024-12-03

<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Burning Behav. at 0.75 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
<b><i>OTHER PROPERTIES</i></b>	<b><i>DRY / COND</i></b>		
Density	1230 / –	kg/m <sup>3</sup>	ISO 1183
<b><i>PROCESSING RECOMMENDATIONS</i></b>	<b><i>VALUE</i></b>		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Melt temperature (Tmin – Tmax)	260-290	°C	
Mold temperature	80-100	°C	

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