

Durethan® BKV230H3.0

PA*—I—GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized, Improved Impact

Print Date: 2024-09-27

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.2 / *	%	ISO 294-4
Molding shrinkage (normal)	0.7 / *	%	ISO 294-4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	8000 / 4400	MPa	ISO 527-1/-2
Stress at break	125 / 75	MPa	ISO 527-1/-2
Strain at break	4 / 8.5	%	ISO 527-1/-2
Flexural modulus	7500 / 4100	MPa	ISO 178
Flexural strength	205 / 115	MPa	ISO 178
Charpy impact strength (+23°C)	85 / 100	kJ/m ²	ISO 179/1eU
Charpy impact strength (-30°C)	95 / 85	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	20 / 40	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (-30°C)	15 / 15	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	20 / 35	kJ/m ²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	213 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	210 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.2 / *	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.3 / *	E-4/°C	ISO 11359-1/-2
OTHER PROPERTIES			
	DRY / COND		

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Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Water absorption	6 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1300 / –	kg/m ³	ISO 1183

<i>PROCESSING RECOMMENDATIONS</i>	<i>VALUE</i>		
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2–6	h	
Residual moisture content	0.03–0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	260–290	°C	
Mold temperature	80–100	°C	

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