

Durethan[®] BKV25FN01

PA6–GF25 FR(40+72)

25% Glass Reinforced, Injection Molding, Flame Retardant (halogen free), Heat Stabilized, Improved flow

Print Date: 2024–12–10

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294–4
Molding shrinkage (normal)	0.7 / *	%	ISO 294–4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	9300 / 5800	MPa	ISO 527–1/–2
Stress at break	130 / 80	MPa	ISO 527–1/–2
Strain at break	3.1 / 6.5	%	ISO 527–1/–2
Flexural modulus	9000 / 5500	MPa	ISO 178
Flexural strength	205 / 140	MPa	ISO 178
Charpy impact strength (+23°C)	60 / 65	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 13	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (–30°C)	<10 / <10	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / 15	kJ/m ²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	222 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	202 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	220 / *	°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)	0.8 / *	E–4/°C	ISO 11359–1/–2
Burning Behav. at 1.5 mm nom. thickn.	V–0 / *	class	IEC 60695–11–10
Thickness tested	1.5 / *	mm	IEC 60695–11–10
Burning Behav. at 3.0 mm nom. thickn.	V–0 / *	class	IEC 60695–11–10

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.75 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Oxygen index	32 / *	%	ISO 4589-1/-2
Glow Wire Flammability Index GWFI	960 / -	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	0.75 / -	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / -	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	1.5 / -	mm	IEC 60695-2-12
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (1) tested)	1.5 / -	mm	IEC 60695-2-13
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (2) tested)	3 / -	mm	IEC 60695-2-13
<i>ELECTRICAL PROPERTIES</i>	<i>DRY / COND</i>		
Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Electric strength	39 / -	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	V	IEC 60112
<i>OTHER PROPERTIES</i>	<i>DRY / COND</i>		
Water absorption	5 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1390 / -	kg/m³	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	0.03-0.07	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	250-270	°C	

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Mold temperature	80-100	°C	

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