

# Durethan® BKV30FN04 DUS064

## PA6–GF30 FR(40)

30% Glass Reinforced, Injection Molding, Flame Retardant (halogen free), Heat Stabilized

Print Date: 2024–12–10

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Molding shrinkage (parallel)	0.2 / *	%	ISO 294–4
Molding shrinkage (normal)	0.7 / *	%	ISO 294–4
<b>MECHANICAL PROPERTIES</b>			
	<b>DRY / COND</b>		
Tensile modulus	11000 / 7000	MPa	ISO 527–1/–2
Stress at break	140 / 95	MPa	ISO 527–1/–2
Strain at break	3.1 / 6	%	ISO 527–1/–2
Flexural modulus	10200 / 6600	MPa	ISO 178
Flexural strength	235 / 160	MPa	ISO 178
Charpy impact strength (+23°C)	60 / 70	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 13	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	<10 / 13	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)	205 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	219 / *	°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
Thickness tested	3 / *	mm	IEC 60695–11–10

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## Property Data

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Print Date: 2024-12-10

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	1.5 / –	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / –	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	3 / –	mm	IEC 60695-2-12

### ELECTRICAL PROPERTIES

#### DRY / COND

Electric strength	35 / –	kV/mm	IEC 60243-1
Comparative tracking index	600 / –	V	IEC 60112

### OTHER PROPERTIES

#### DRY / COND

Water absorption	4.8 / *	%	Sim. to ISO 62
Humidity absorption	1.6 / *	%	Sim. to ISO 62
Density	1420 / –	kg/m <sup>3</sup>	ISO 1183

### PROCESSING RECOMMENDATIONS

#### VALUE

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)	250-280	°C	
Mold temperature	70-90	°C	

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