

# Durethan<sup>®</sup> BKV30FN04LT

## PA6–GF60 FR(40)

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

Print Date: 2024–08–24

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	10300 / 6700	MPa	ISO 527–1/–2
Stress at break	130 / 90	MPa	ISO 527–1/–2
Strain at break	3 / 6	%	ISO 527–1/–2
Flexural modulus	10200 / 6600	MPa	ISO 178
Flexural strength	230 / 158	MPa	ISO 178
Charpy impact strength (+23°C)	60 / 68	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (–30°C)	55 / 50	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10 / 13	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (–30°C)	<10 / –	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	5VA / *	mm	IEC 60695–11–10

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Burning Behav. at 3.0 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	3 / *	mm	IEC 60695-11-10
Burning Behav. at 0.4 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.4 / *	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)	0.4 / -	mm	IEC 60695-2-12
Glow Wire Flammability Index GWFI	960 / -	°C	IEC 60695-2-12
GWFI (Thickness (2) tested)	0.75 / -	mm	IEC 60695-2-12
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (1) tested)	0.4 / -	mm	IEC 60695-2-13
Glow Wire Ignition Temperature GWIT	775 / -	°C	IEC 60695-2-13
GWIT (Thickness (2) tested)	0.75 / -	mm	IEC 60695-2-13
<b>ELECTRICAL PROPERTIES</b>	<b>DRY / COND</b>		
Relative permittivity (100Hz)	4 / 8	-	IEC 62631-2-1
Relative permittivity (1 MHz)	3.6 / 3.9	-	IEC 62631-2-1
Dissipation factor (100 Hz)	145 / 1130	E-4	IEC 62631-2-1
Dissipation factor (1 MHz)	155 / 655	E-4	IEC 62631-2-1
Volume resistivity	>1E13 / 2.1E11	Ohm*m	IEC 62631-3-1
Electric strength	40 / 37	kV/mm	IEC 60243-1
Comparative tracking index	600 / -	V	IEC 60112
<b>OTHER PROPERTIES</b>	<b>DRY / COND</b>		
Water absorption	4.6 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1420 / -	kg/m³	ISO 1183

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<b>PROCESSING RECOMMENDATIONS</b>			
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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