

# Durethan® BKV30XWPLT

## PA6–GF30

30% Glass Reinforced, Injection Molding, Heat Stabilized, Laser Weldable, Laser Transparent Black

Print Date: 2024–10–08

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Molding shrinkage (parallel)	0.19 / *	%	ISO 294–4
Molding shrinkage (normal)	0.35 / *	%	ISO 294–4
<b>MECHANICAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Tensile modulus	9500 / 7250	MPa	ISO 527–1/–2
Stress at break	175 / 120	MPa	ISO 527–1/–2
Strain at break	3.6 / 5.8	%	ISO 527–1/–2
Flexural modulus	8600 / 6300	MPa	ISO 178
Flexural strength	270 / 180	MPa	ISO 178
Izod notched impact strength (+23°C)	11 / 13	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL PROPERTIES</b>			
	<i>DRY / COND</i>		
Melting temperature (10°C/min)	222 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	188 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75–1/–2
<b>OTHER PROPERTIES</b>			
	<i>DRY / COND</i>		
Density	1360 / –	kg/m <sup>3</sup>	ISO 1183
<b>MATERIAL SPECIFIC PROPERTIES</b>			
	<i>DRY / COND</i>		
Viscosity number	125 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

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## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
<b>PROCESSING RECOMMENDATIONS</b>			
Drying temperature dry air dryer	80	°C	
Drying time dry air dryer	2-6	h	
Residual moisture content	0.03-0.12	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	270-290	°C	
Mold temperature	80-120	°C	

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