

Durethan® BKV35H2.0 DUS038

PA6–GF35

35% Glass Reinforced, Injection Molding, Excellent Surface Properties

Print Date: 2024–08–24

| PROPERTIES | TYPICAL DATA | UNIT | TEST METHOD |
|--|-------------------|-------------------|----------------|
| RHEOLOGICAL PROPERTIES | | | |
| | DRY / COND | | |
| Molding shrinkage (parallel) | 0.25 / * | % | ISO 294–4 |
| Molding shrinkage (normal) | 0.7 / * | % | ISO 294–4 |
| MECHANICAL PROPERTIES | | | |
| | DRY / COND | | |
| Tensile modulus | 10500 / 6800 | MPa | ISO 527–1/–2 |
| Stress at break | 170 / 110 | MPa | ISO 527–1/–2 |
| Strain at break | 3 / 5 | % | ISO 527–1/–2 |
| Flexural modulus | 10000 / 5900 | MPa | ISO 178 |
| Flexural strength | 270 / 170 | MPa | ISO 178 |
| Charpy impact strength (+23°C) | 80 / 90 | kJ/m ² | ISO 179/1eU |
| Charpy impact strength (–30°C) | 70 / 70 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength (+23°C) | 10 / 15 | 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) | 13 / 15 | kJ/m ² | ISO 180/1A |
| THERMAL PROPERTIES | | | |
| | DRY / COND | | |
| Melting temperature (10°C/min) | 220 / * | °C | ISO 11357–1/–3 |
| Temp. of deflection under load (1.80 MPa) | 200 / * | °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) | 0.8 / * | 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 | 6.5 / * | % | Sim. to ISO 62 |
| Humidity absorption | 1.9 / * | % | Sim. to ISO 62 |
| Density | 1410 / – | 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) | 270–290 | °C | |
| Mold temperature | 80–120 | °C | |

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