

Durethan® BKV35XWPXT

PA6–GF35

35% Glass Reinforced, Injection Molding, Heat Stabilized, Laser Weldable

Print Date: 2024–08–24

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294–4
Molding shrinkage (normal)	0.65 / *	%	ISO 294–4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	11500 / 6000	MPa	ISO 527–1/–2
Stress at break	175 / 110	MPa	ISO 527–1/–2
Strain at break	4.5 / 9.5	%	ISO 527–1/–2
Flexural modulus	10200 / 5700	MPa	ISO 178
Flexural strength	280 / 160	MPa	ISO 178
Tensile modulus (200°C)	2890	MPa	ISO 527–1/–2
Charpy impact strength (+23°C)	105 / 115	kJ/m ²	ISO 179/1eU
Charpy impact strength (–30°C)	95 / 85	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	15 / 30	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)	15 / 35	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)	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)	1 / *	E–4/°C	ISO 11359–1/–2

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
OTHER PROPERTIES			
Density	1410 / –	kg/m ³	ISO 1183
PROCESSING RECOMMENDATIONS			
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	
admissible residence time at Tmax	<5	min	

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