

# Durethan® BKV60XF

## PA6–GF60

60% Glass Reinforced, Injection Molding, Heat Stabilized, Improved flow

Print Date: 2024–08–24

| PROPERTIES                                   | TYPICAL DATA      | UNIT   | TEST METHOD    |
|----------------------------------------------|-------------------|--------|----------------|
| <b>RHEOLOGICAL PROPERTIES</b>                |                   |        |                |
|                                              | <b>DRY / COND</b> |        |                |
| Molding shrinkage (parallel)                 | 0.25 / *          | %      | ISO 294–4      |
| Molding shrinkage (normal)                   | 0.52 / *          | %      | ISO 294–4      |
| <b>MECHANICAL PROPERTIES</b>                 |                   |        |                |
|                                              | <b>DRY / COND</b> |        |                |
| Tensile modulus                              | 20200 / 13000     | MPa    | ISO 527–1/–2   |
| Stress at break                              | 215 / 140         | MPa    | ISO 527–1/–2   |
| Strain at break                              | 2.3 / 2.8         | %      | ISO 527–1/–2   |
| Flexural modulus                             | 18500 / 14000     | MPa    | ISO 178        |
| Flexural strength                            | 350 / 230         | MPa    | ISO 178        |
| Tensile modulus (200°C)                      | 5760              | MPa    | ISO 527–1/–2   |
| Charpy impact strength (+23°C)               | 88 / –            | kJ/m²  | ISO 179/1eU    |
| Charpy notched impact strength (+23°C)       | 15 / –            | kJ/m²  | ISO 179/1eA    |
| Izod notched impact strength (+23°C)         | 15 / –            | kJ/m²  | ISO 180/1A     |
| <b>THERMAL PROPERTIES</b>                    |                   |        |                |
|                                              | <b>DRY / COND</b> |        |                |
| Melting temperature (10°C/min)               | 221 / *           | °C     | ISO 11357–1/–3 |
| Temp. of deflection under load (1.80 MPa)    | 208 / *           | °C     | ISO 75–1/–2    |
| Temp. of deflection under load (0.45 MPa)    | 217 / *           | °C     | ISO 75–1/–2    |
| Coeff. of linear therm. expansion (parallel) | 0.11 / *          | E–4/°C | ISO 11359–1/–2 |
| Coeff. of linear therm. expansion (normal)   | 0.85 / *          | E–4/°C | ISO 11359–1/–2 |
| <b>OTHER PROPERTIES</b>                      |                   |        |                |
|                                              | <b>DRY / COND</b> |        |                |
| Density                                      | 1690 / –          | kg/m³  | ISO 1183       |

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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         | 0.05-0.15           | %           | acc. to Karl Fischer |
| Melt temperature (Tmin – Tmax)    | 270-290             | °C          |                      |
| Mold temperature                  | 80-120              | °C          |                      |

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