

Datasheet Durethan BKV40H2.0EF 900116

PA 6, 40% glass fibers, injection molding, improved flowability, heat-aging stabilized

ISO Shortname: ISO 16396-PA 6,GF40,GHR,S10-120

C Tensile Stress at break 5 mm/min MPa ISO 527-1,-2 190 110 C Tensile Strain at break 5 mm/min % ISO 527-1,-2 3 5 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C	Property	Test Condition	Unit	Standard	rd guide value 1 d.a.m. cond.	
°C; 600 bar CMolding shrinkage, transverse 60x60x2; 280 °C / MT 80 % ISO 294-4 0.65 Post-shrinkage, parallel 60x60x2; 120 °C; 4 h % ISO 294-4 0.05 Post-shrinkage, transverse 60x60x2; 120 °C; 4 h % ISO 294-4 0.10 Mechanical properties (23 °C/50 % r. h.) CTensile Strain at properties (23 °C/50 % r. h.) Tmm/min MPa ISO 527-1,-2 12200 7200 CTensile Strain at break 5 mm/min MPa ISO 527-1,-2 190 110 CTensile Strain at break 5 mm/min MPa ISO 527-1,-2 3 5 CCharpy impact strength 23 °C k.//m² ISO 179-1eU 90 90 CCharpy inpact strength -30 °C k.//m² ISO 179-1eA 12 12 Izod impact strength 23 °C k.//m² ISO 179-1eA 12 12 Izod impact strength 23 °C k.//m² ISO 180-1U 75 80 Izod notched impact strength 23 °C k.//m² ISO 180-1A 15 23 Izod notched imp	Rheological properties					
°C; 600 bar Post-shrinkage, parallel 60x60x2; 120 °C; 4 h % ISO 294-4 0.05 Post-shrinkage, transverse 60x60x2; 120 °C; 4 h % ISO 294-4 0.10 Mechanical properties (23 °C/50 % r. h.) C Tornsile Sto 294-4 0.10 Crensile modulus 1 mm/min MPa ISO 297-1,-2 12200 7200 CTensile modulus 1 mm/min MPa ISO 527-1,-2 190 1100 CTensile stress at break 5 mm/min MPa ISO 527-1,-2 190 1100 CTensile strength 23 °C kJ/m² ISO 179-1eU 90 90 CCharpy impact strength 23 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 180-11 75 80 Izod notched impact strength 30 °C kJ/m² ISO 180-14 15 23 Izod notched impact strength 30 °C kJ/m	C Molding shrinkage, parallel		%	ISO 294-4	0.20	
Post-shrinkage, transverse 60x60x2; 120 °C; 4 h % ISO 294-4 0.10 Mechanical properties (23 °C/50 % r. h.) C Imm/min MPa ISO 527-1,-2 12200 7200 C Tensile modulus 1 mm/min MPa ISO 527-1,-2 190 110 C Tensile Strain at break 5 mm/min MPa ISO 527-1,-2 3 5 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 180-1U 75 80 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod notched impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod inpact strength 23 °C kJ/m² ISO 180-1U 75 70 Izod inpact strength 23 °C<	C Molding shrinkage, transverse		%	ISO 294-4	0.65	
Mechanical properties (23 °C/50 % r. h.) C Tensile modulus 1 mm/min MPa ISO 527-1,-2 12200 7200 C Tensile Stress at break 5 mm/min MPa ISO 527-1,-2 190 1100 C Tensile Strain at break 5 mm/min % ISO 527-1,-2 3 5 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 70 70 C Charpy inpact strength 23 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod impact strength 30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 I	Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.05	
C Tensile modulus 1 mm/min MPa ISO 527-1,-2 12200 7200 C Tensile Stress at break 5 mm/min MPa ISO 527-1,-2 190 110 C Tensile Strain at break 5 mm/min % ISO 527-1,-2 3 5 C Charpy impact strength 23 °C k.//m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C k.//m² ISO 179-1eU 70 70 C Charpy notched impact strength 23 °C k.//m² ISO 179-1eA 13 20 C Charpy notched impact strength 23 °C k.//m² ISO 179-1eA 13 20 C Charpy notched impact strength 23 °C k.//m² ISO 179-1eA 12 12 Izod impact strength 23 °C k.//m² ISO 180-1U 75 80 Izod impact strength -30 °C k.//m² ISO 180-1U 75 70 Izod notched impact strength 23 °C k.//m² ISO 180-1A 15 23 Izod notched impact strength 2 °C	Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.10	
C Tensile Stress at break 5 mm/min MPa ISO 527-1,-2 190 110 C Tensile Strain at break 5 mm/min % ISO 527-1,-2 3 5 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 80 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural strength -30 °C kJ/m² </td <td>Mechanical properties (23 °C/50 % r. h.)</td> <td></td> <td></td> <td></td> <td></td> <td></td>	Mechanical properties (23 °C/50 % r. h.)					
CTensile Strain at break 5 mm/min % ISO 527-1,-2 3 5 C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy motched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 1500 6800 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa I	C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	12200	7200
C Charpy impact strength 23 °C kJ/m² ISO 179-1eU 90 90 C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength 23 °C kJ/m² ISO 178-A 1150 6800 Flexural strength 2 mm/min <t< td=""><td>C Tensile Stress at break</td><td>5 mm/min</td><td>MPa</td><td>ISO 527-1,-2</td><td>190</td><td>110</td></t<>	C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	190	110
C Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 1500 6800 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa I	C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	3	5
C Charpy notched impact strength 23 °C kJ/m² ISO 179-1eA 13 20 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 6603-2	C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	90	90
C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA 12 12 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 1200 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 6603-2 900 00 CPuncture maximum force -30 °C N ISO 6603-2	C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	70	70
Izod impact strength 23 °C kJ/m² ISO 180-1U 75 80 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strengt 2 mm/min % ISO 178-A 3.2 4.8 Flexural strengt 2 mm/min MPa ISO 178-A 3.2 4.8 CPuncture maximum force 23 °C N ISO 6603-2 900 170 CPuncture energy 23 °C J ISO 6603-2 3.5 <	C Charpy notched impact strength	23 °C	kJ/m²	ISO 179-1eA	13	20
Izod impact strength -30 °C kJ/m² ISO 180-1U 75 70 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strengt 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 6603-2 900 0 C Puncture maximum force -30 °C N ISO 6603-2 3.5	C Charpy notched impact strength	-30 °C	kJ/m²	ISO 179-1eA	12	12
Izod notched impact strength 23 °C kJ/m² ISO 180-1A 15 23 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min % ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural strength 2 mm/min MPa ISO 6603-2 900 0 C Puncture maximum force -30 °C N ISO 6603-2 3.5 0 C Puncture energy 23 °C J ISO 6603-2 3.5 0 0 C Puncture energy -30 °C J ISO 6603-2 2.7	Izod impact strength	23 °C	kJ/m²	ISO 180-1U	75	80
Izod notched impact strength -30 °C kJ/m² ISO 180-1A 12 12 Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 170 C Puncture maximum force 23 °C N ISO 6603-2 900 C Puncture energy 23 °C J ISO 6603-2 2.7 C Puncture energy -30 °C J ISO 6603-2 2.7 C M	Izod impact strength	-30 °C	kJ/m²	ISO 180-1U	75	70
Flexural modulus 2 mm/min MPa ISO 178-A 11500 6800 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strength 2 mm/min % ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 170 C Puncture maximum force 23 °C N ISO 6603-2 900 900 C Puncture energy 23 °C J ISO 6603-2 770 70 70 C Puncture energy 23 °C J ISO 6603-2 2.7 70 70 C Puncture energy -30 °C J ISO 6603-2 2.7 70 70 C Puncture energy -30 °C J ISO 6603-2 2.7 70 70 C Melting temperature 10 °C/min °C	Izod notched impact strength	23 °C	kJ/m²	ISO 180-1A	15	23
Flexural strength 2 mm/min MPa ISO 178-A 290 190 Flexural strain at flexural strength 2 mm/min % ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.2 4.8 CPuncture maximum force 23 °C N ISO 6603-2 900 70 C Puncture energy 23 °C J ISO 6603-2 3.5 70 C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties - - - SO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C <t< td=""><td>Izod notched impact strength</td><td>-30 °C</td><td>kJ/m²</td><td>ISO 180-1A</td><td>12</td><td>12</td></t<>	Izod notched impact strength	-30 °C	kJ/m²	ISO 180-1A	12	12
Flexural strain at flexural strength 2 mm/min % ISO 178-A 3.2 4.8 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 170 C Puncture maximum force 23 °C N ISO 6603-2 900 C Puncture maximum force -30 °C N ISO 6603-2 770 C Puncture energy 23 °C J ISO 6603-2 3.5 C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties -30 °C J ISO 6603-2 2.7 C Melting temperature 10 °C/min °C ISO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	Flexural modulus	2 mm/min	MPa	ISO 178-A	11500	6800
Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 170 C Puncture maximum force 23 °C N ISO 6603-2 900 </td <td>Flexural strength</td> <td>2 mm/min</td> <td>MPa</td> <td>ISO 178-A</td> <td>290</td> <td>190</td>	Flexural strength	2 mm/min	MPa	ISO 178-A	290	190
C Puncture maximum force 23 °C N ISO 6603-2 900 C Puncture maximum force -30 °C N ISO 6603-2 770 C Puncture energy 23 °C J ISO 6603-2 3.5 C Puncture energy -30 °C J ISO 6603-2 3.5 C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties -30 °C J ISO 11357-1,-3 220 C Melting temperature 10 °C/min °C ISO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	3.2	4.8
C Puncture maximum force -30 °C N ISO 6603-2 770 C Puncture energy 23 °C J ISO 6603-2 3.5 C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties -30 °C J ISO 6603-2 2.7 C Melting temperature 10 °C/min °C ISO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A		170
C Puncture energy 23 °C J ISO 6603-2 3.5 C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties C ISO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	C Puncture maximum force	23 °C	Ν	ISO 6603-2	900	
C Puncture energy -30 °C J ISO 6603-2 2.7 Thermal properties C ISO 11357-1,-3 220 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	C Puncture maximum force	-30 °C	Ν	ISO 6603-2	770	
Thermal properties°CISO 11357-1,-3220C Melting temperature10 °C/min°CISO 11357-1,-3220C Temperature of deflection under load1.80 MPa°CISO 75-1,-2210	C Puncture energy	23 °C	J	ISO 6603-2	3.5	
C Melting temperature10 °C/min°CISO 11357-1,-3220C Temperature of deflection under load1.80 MPa°CISO 75-1,-2210	C Puncture energy	-30 °C	J	ISO 6603-2	2.7	
C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 210	Thermal properties					
	C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	220	
C Temperature of deflection under load 0.45 MPa °C ISO 75-1,-2 220	C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	210	
	C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	220	
C Coefficient of linear thermal expansion, parallel 23 to 55 °C 10 ⁻⁴ /K ISO 11359-1,-2 0.15	C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ^{-₄} /K	ISO 11359-1,-2	0.15	
C Coefficient of linear thermal expansion, transverse 23 to 55 °C $10^{4}/K$ ISO 11359-1,-2 1	C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1	
Other properties (23 °C)	Other properties (23 °C)					
C Water absorption (Saturation value) Water at 23 °C % ISO 62 5.8	C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	5.8	



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Property	Test Condition	Unit	Standard	guide value ¹
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	1.7
C Density		kg/m³	ISO 1183	1450
Bulk density		kg/m³	ISO 60	700
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	280
C Injection molding-Mold temperature		°C	ISO 294	80
Processing recommendations				
Drying temperature dry air dryer		°C	-	80
Drying time dry air dryer		h	-	2-6
Residual moisture content		%	Acc. to Karl Fischer	0.03-0.12
Melt temperature (Tmin - Tmax)		°C	-	270-290
Mold temperature		°C	-	80-120

Notes

1 Typical properties: these are not to be construed as specifications

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.



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Disclaimer

Disclaimer for commercial products

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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

Conditioning

Conditioning in accordance with ISO 1110 (70 °C; 62 % r.h.)

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