

# Durethan BKV25F30 00000 DUS013

PA 6, 25 % glass fibers, injection molding, flame retardant, heat-aging stabilized, optimized for laser marking (1064nm)

ISO Shortname: ISO 16396-PA 6,GF25 FR(17),GF2HR.S14-110

Property	Test Condition	Unit	Standard	guide value <sup>1</sup>	
				d.a.m.	cond.
<b>Rheological properties</b>					
Molding shrinkage, parallel	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 2577	0.3	
Molding shrinkage, transverse	150x105x3; 280 °C / MT 80 °C; 500 bar	%	acc. ISO 2577	0.6	
Post- shrinkage, parallel	150x105x3; 120 °C; 4 h	%	acc. ISO 2577	0.1	
Post- shrinkage, transverse	150x105x3; 120 °C; 4 h	%	acc. ISO 2577	0.1	
<b>Mechanical properties (23 °C/50 % r. h.)</b>					
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	11000	7300
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	150	90
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	2.3	4.4
C Charpy impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eU	55	55
C Charpy impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eU	45	50
C Charpy notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179-1eA	<10	15
C Charpy notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 179-1eA	<10	<10
Izod impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1U	50	55
Izod impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1U	45	50
Izod notched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 180-1A	10	15
Izod notched impact strength	-30 °C	kJ/m <sup>2</sup>	ISO 180-1A	<10	<10
Flexural modulus	2 mm/min	MPa	ISO 178-A	10000	7000
Flexural strength	2 mm/min	MPa	ISO 178-A	230	155
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	2.5	4
C Puncture maximum force	23 °C	N	ISO 6603-2	1000	
C Puncture maximum force	-30 °C	N	ISO 6603-2	900	
C Puncture energy	23 °C	J	ISO 6603-2	3	
C Puncture energy	-30 °C	J	ISO 6603-2	1.9	
<b>Thermal properties</b>					
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	222	
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	205	
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	215	
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	205	
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	0.2	
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 <sup>-4</sup> /K	ISO 11359-1,-2	0.9	
C Burning behavior UL 94	1.5 mm	Class	UL 94	V-0	
C Burning behavior UL 94	0.4 mm	Class	UL 94	V-0	
C Burning behavior UL 94-5V	1.5 mm	Class	UL 94	5VA	
Burning behavior UL 94-5V	1.0 mm	Class	UL 94	5VA	
Burning behavior UL 94-5V	3.0 mm	Class	UL 94	5VA	
Glow wire test (GWFI)	0.4 mm	°C	IEC 60695-2-12	960	
Glow wire test (GWFI)	0.75 mm	°C	IEC 60695-2-12	960	
Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	960	



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Property	Test Condition	Unit	Standard	guide value <sup>1</sup> d.a.m. cond.
Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	960
Glow wire test (GWIT)	0.4 mm	°C	IEC 60695-2-13	850
Glow wire test (GWIT)	0.75 mm	°C	IEC 60695-2-13	850
Glow wire test (GWIT)	1.5 mm	°C	IEC 60695-2-13	850
Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	850
Burning behavior US-FMVSS302			ISO 3795	passed
<b>Electrical properties (23 °C/50 % r. h.)</b>				
C Volume resistivity		Ohm·m	IEC 60093	3.4E12
Surface resistivity		Ohm	IEC 60167	4.1E13
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	400
<b>Other properties (23 °C)</b>				
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	4.3
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	1.3
C Density		kg/m <sup>3</sup>	ISO 1183	1610
<b>Processing conditions for test specimens</b>				
C Injection molding-Melt temperature		°C	ISO 294	280
C Injection molding-Mold temperature		°C	ISO 294	80
<b>Processing recommendations</b>				
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	-	80-100

### 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

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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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