

**Durethan BKV215 000000**  
**PA6-I-GF15**

LANXESS Deutschland GmbH

PA 6-Copolymer, 15 % glass fibers, injection molding, improved impact strength

| Rheological properties      | dry / cond | Unit | Test Standard   |
|-----------------------------|------------|------|-----------------|
| <b>ISO Data</b>             |            |      |                 |
| Molding shrinkage, parallel | 0.6 / *    | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal   | 0.6 / *    | %    | ISO 294-4, 2577 |

| Mechanical Properties                  | dry / cond  | Unit  | Test Standard |
|----------------------------------------|-------------|-------|---------------|
| <b>ISO Data</b>                        |             |       |               |
| Tensile Modulus                        | 4500 / 2400 | MPa   | ISO 527       |
| Stress at break                        | 85 / 55     | MPa   | ISO 527       |
| Strain at break                        | 4.5 / 15    | %     | ISO 527       |
| Charpy impact strength (+23°C)         | 70 / 80     | kJ/m² | ISO 179/1eU   |
| Charpy impact strength, -30°C          | 80 / 75     | kJ/m² | ISO 179/1eU   |
| Charpy notched impact strength (+23°C) | 20 / 35     | kJ/m² | ISO 179/1eA   |
| Charpy notched impact strength, -30°C  | 12 / 12     | kJ/m² | ISO 179/1eA   |
| Puncture - maximum force, +23°C        | 1000 / -    | N     | ISO 6603-2    |
| Puncture - maximum force, -30°C        | 650 / -     | N     | ISO 6603-2    |
| Puncture energy, +23°C                 | 13 / 32     | J     | ISO 6603-2    |
| Puncture energy, -30°C                 | 4.8 / -     | J     | ISO 6603-2    |

| Thermal Properties                          | dry / cond | Unit  | Test Standard  |
|---------------------------------------------|------------|-------|----------------|
| <b>ISO Data</b>                             |            |       |                |
| Melting temperature (10°C/min)              | 214 / *    | °C    | ISO 11357-1/-3 |
| Temp. of deflection under load (1.80 MPa)   | 175 / *    | °C    | ISO 75-1/-2    |
| Temp. of deflection under load (0.45 MPa)   | 205 / *    | °C    | ISO 75-1/-2    |
| Coeff. of linear therm. expansion, parallel | 40 / *     | E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal   | 150 / *    | E-6/K | ISO 11359-1/-2 |
| Burning behav. at 1.5 mm nom. thickn.       | HB / *     | class | UL 94          |
| Thickness tested                            | 1.5 / *    | mm    | -              |
| Oxygen index                                | 22 / *     | %     | ISO 4589-1/-2  |

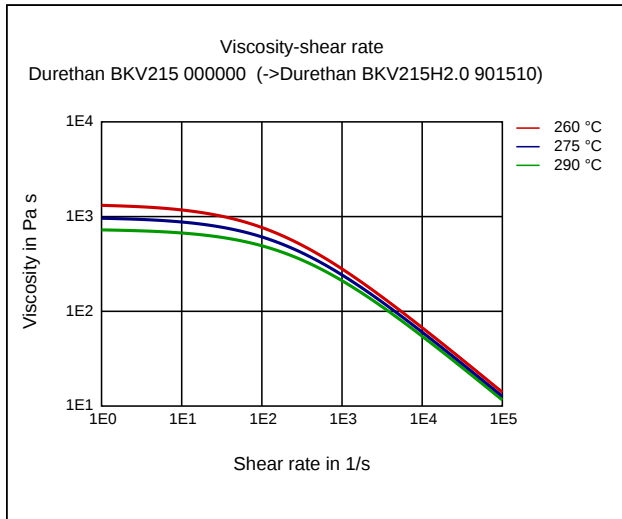
| Electrical Properties        | dry / cond  | Unit  | Test Standard |
|------------------------------|-------------|-------|---------------|
| <b>ISO Data</b>              |             |       |               |
| Relative permittivity, 100Hz | 3.5 / 10    | -     | IEC 62631-2-1 |
| Relative permittivity, 1MHz  | 3.2 / 3.7   | -     | IEC 62631-2-1 |
| Dissipation factor, 100Hz    | 60 / 1500   | E-4   | IEC 62631-2-1 |
| Dissipation factor, 1MHz     | 150 / 800   | E-4   | IEC 62631-2-1 |
| Volume resistivity           | 1E11 / 1E10 | Ohm*m | IEC 62631-3-1 |
| Surface resistivity          | * / 1E13    | Ohm   | IEC 62631-3-2 |
| Electric strength            | 43 / 43     | kV/mm | IEC 60243-1   |
| Comparative tracking index   | 600 / -     | -     | IEC 60112     |

| Other Properties    | dry / cond | Unit  | Test Standard  |
|---------------------|------------|-------|----------------|
| <b>ISO Data</b>     |            |       |                |
| Water absorption    | 7 / *      | %     | Sim. to ISO 62 |
| Humidity absorption | 2 / *      | %     | Sim. to ISO 62 |
| Density             | 1180 / -   | kg/m³ | ISO 1183       |

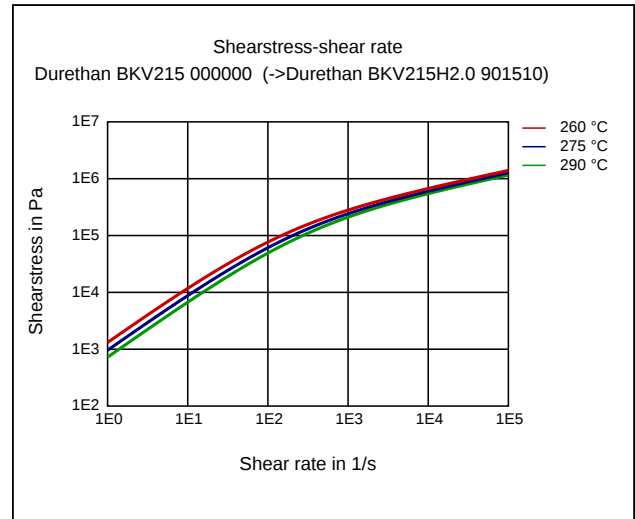
| Test specimen production            | Value | Unit | Test Standard |
|-------------------------------------|-------|------|---------------|
| <b>ISO Data</b>                     |       |      |               |
| Injection Molding, melt temperature | 280   | °C   | ISO 294       |
| Injection Molding, mold temperature | 80    | °C   | ISO 294       |

## Diagrams

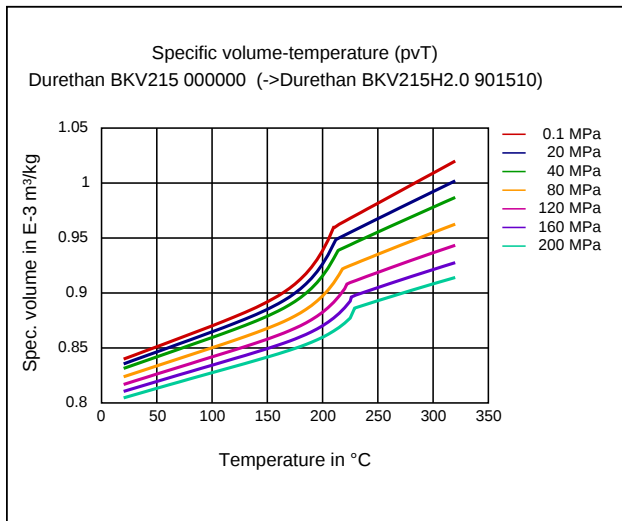
### Viscosity-shear rate



### Shearstress-shear rate



### Specific volume-temperature (pvT)



## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets

### Injection Molding

#### PREPROCESSING

Residual moisture content: 0.03-0.12 %

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer: 2-6 h

#### PROCESSING

Melt temperature (Tmin - Tmax): 260-290 °C

### Special Characteristics

Impact modified

Mold temperature: 80-100 °C

#### Disclaimer

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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