X

Durethan BKV35H2.0 901510 DUS038

PA 6, 35 % glass fibers, injection molding, heat-aging stabilized, improved surface finish

ISO Shortname: ISO 16396-PA 6,GF35,GHR,S14-110

Rhebogical properties C Molding shrinkage, parallel 60x60x2; 280 °C / MT 80 % ISO 294.4 0.7 C Molding shrinkage, transverse 60x60x2; 280 °C / MT 80 % ISO 294.4 0.7 Post-shrinkage, transverse 60x60x2; 280 °C / MT 80 % ISO 294.4 0.7 Post-shrinkage, transverse 60x60x2; 120 °C; 4 h % ISO 294.4 0.05 Mechanical properties (23 °C50 % r. h.) 0 1 Mechanical properties (23 °C50 % r. h.) 0 C Tensile Stress at break 5 mm/min MPa ISO 527.1, 2 10000 6800 C Tensile Stress at break 5 mm/min MPa ISO 527.1, 2 100 100 C Tensile Stress at break 5 mm/min MPa ISO 527.1, 2 10 10 C Chargin grad strength 23 °C k.//m ² ISO 179-140 80 90 C Chargin grad strength 23 °C k.//m ² ISO 180-10 75 85 Izod inpact strength 23 °C k.//m ² ISO 180-110 75 85 Izod inpact strength 30 °C	Property	Test Condition	Unit	Standard	guide value d.a.m.	cond.
°C; 600 bar CMolding shrinkage, transverse 60x60x2; 220 °C; MT 80 % ISO 294-4 0.7 Post-shrinkage, parallel 60x60x2; 120 °C; 4 h % ISO 294-4 0.05 Post-shrinkage, transverse 60x60x2; 120 °C; 4 h % ISO 294-4 0.05 Mechanical properties (23 °C/50 % r. h.) CTensile modulus 1 mm/min MPa ISO 527-1,-2 10500 6800 CTensile Stress at break 5 mm/min MPa ISO 527-1,-2 3 5 CCharpy impact strength 23 °C k.//m² ISO 179-1eU 80 90 CCharpy mode strength -30 °C k.//m² ISO 179-1eA 10 15 CCharpy mode strength -30 °C k.//m² ISO 180-1U 70 65 Izod impact strength -30 °C k.//m² ISO 180-1U 75 85 Izod notched impact strength -30 °C k.//m² ISO 180-1A 10 10 Flexural strength -30 °C k.//m² ISO 180-1A 10 10 Izod no	Rheological properties					
*C: 600 bar Post-shrinkage, parallel 60x60x2; 120 °C; 4 h % ISO 294-4 0.05 Mechanical properties (23 °C/50 % r. h.) CTensile modulus 1 mm/min MPa ISO 527-1,-2 10500 6800 CTensile Stras at break 5 mm/min MPa ISO 527-1,-2 170 110 CTensile Strain at break 5 mm/min MPa ISO 527-1,-2 3 5 Charpy inpact strength 23 °C kJ/m² ISO 179-1eU 80 90 C Charpy notched inpact strength 23 °C kJ/m² ISO 179-1eA 10 15 C Charpy notched inpact strength 23 °C kJ/m² ISO 179-1eA 10 15 Izod inpact strength 23 °C kJ/m² ISO 180-10 70 85 Izod inpact strength 23 °C kJ/m² ISO 180-11 75 85 Izod inpact strength 30 °C kJ/m² ISO 180-10 76 55 Izod inpact strength 30 °C kJ/m² ISO 180-11 76 10	C Molding shrinkage, parallel		%	ISO 294-4	0.25	
Post-shrinkage, transverse 60x80x2; 120 °C; 4 h % ISO 294-4 0.15 Mechanical properties (23 °C/50 % r. h.) C CTensile modulus 1 mm/min MPa ISO 527-1,-2 10500 6800 CTensile Strain at break 5 mm/min MPa ISO 527-1,-2 3 5 CCharpy impact strength 23 °C k/lm² ISO 179-1eU 80 90 CCharpy notched impact strength -30 °C k/lm² ISO 179-1eA 10 15 CCharpy notched impact strength -30 °C k/lm² ISO 179-1eA 10 15 Izod impact strength 23 °C k/lm² ISO 180-1U 75 85 Izod inpact strength -30 °C k/lm² ISO 180-1U 70 65 Izod notched impact strength 23 °C k/lm² ISO 180-1A 13 15 Izod notched impact strength 23 °C k/lm² ISO 180-1A 10 10 Flexural strength 23 °C k/lm² ISO 178-A 100 10	C Molding shrinkage, transverse		%	ISO 294-4	0.7	
Mechanical properties (23 °C/50 % r. h.) CTensile modulus 1 mm/min MPa ISO 527-1;-2 10500 6800 CTensile Stress at break 5 mm/min MPa ISO 527-1;-2 170 110 CTensile Stress at break 5 mm/min MPa ISO 527-1;-2 3 5 CCharpy impact strength 23 °C kJ/m² ISO 179-1eU 80 90 CCharpy inpact strength 30 °C kJ/m² ISO 179-1eU 70 70 CCharpy notched impact strength 23 °C kJ/m² ISO 179-1eA 10 12 Izod impact strength 23 °C kJ/m² ISO 179-1eA 10 10 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 85 Izod inpact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 410 10 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength<	Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.05	
CTensile modulus 1 mm/min MPa ISO 527-1,-2 10500 6800 CTensile Stress at break 5 mm/min MPa ISO 527-1,-2 170 110 CTensile Stress at break 5 mm/min % ISO 527-1,-2 3 5 CCharpy impact strength 23 °C k.//m² ISO 179-1eU 70 70 CCharpy notched impact strength -30 °C k.//m² ISO 179-1eA 10 15 CCharpy notched impact strength -30 °C k.//m² ISO 179-1eA 10 10 Izod impact strength 23 °C k.//m² ISO 179-1eA 10 10 Izod impact strength 23 °C k.//m² ISO 180-1U 75 85 Izod inpact strength -30 °C k.//m² ISO 180-1A 13 15 Izod notched impact strength -30 °C k.//m² ISO 180-1A 13 15 Izod notched impact strength -30 °C k.//m² ISO 180-1A 10 10 Flexural strength 2 mm/min MPa <td>Post- shrinkage, transverse</td> <td>60x60x2; 120 °C; 4 h</td> <td>%</td> <td>ISO 294-4</td> <td>0.15</td> <td></td>	Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.15	
CTensile modulus 1 mm/min MPa ISO 527-1,-2 10500 6800 CTensile Stress at break 5 mm/min MPa ISO 527-1,-2 170 110 CTensile Stress at break 5 mm/min % ISO 527-1,-2 3 5 CCharpy impact strength 23 °C k.//m² ISO 179-1eU 70 70 CCharpy notched impact strength -30 °C k.//m² ISO 179-1eA 10 15 CCharpy notched impact strength -30 °C k.//m² ISO 179-1eA 10 10 Izod impact strength 23 °C k.//m² ISO 179-1eA 10 10 Izod impact strength 23 °C k.//m² ISO 180-1U 75 85 Izod inpact strength -30 °C k.//m² ISO 180-1A 13 15 Izod notched impact strength -30 °C k.//m² ISO 180-1A 13 15 Izod notched impact strength -30 °C k.//m² ISO 180-1A 10 10 Flexural strength 2 mm/min MPa <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 CCharpy impact strength 23 °C kJ/m² ISO 179-1eU 80 90 CCharpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 CCharpy notched impact strength 23 °C kJ/m² ISO 179-1eA 10 15 CCharpy notched impact strength 23 °C kJ/m² ISO 179-1eA <10		1 mm/min	MPa	ISO 527-1,-2	10500	6800
CCharpy impact strength 23 °C kJ/m² ISO 179-1eU 80 90 CCharpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 CCharpy notched impact strength 23 °C kJ/m² ISO 179-1eA 10 15 CCharpy notched impact strength -30 °C kJ/m² ISO 180-1U 75 85 Izod impact strength -30 °C kJ/m² ISO 180-1U 75 85 Izod inpact strength -30 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 410 10 Flexural strength 23 °C kJ/m² ISO 180-1A 410 10 Flexural strength 23 °C kJ/m² ISO 180-1A 410 10 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A </td <td>C Tensile Stress at break</td> <td>5 mm/min</td> <td>MPa</td> <td>ISO 527-1,-2</td> <td>170</td> <td>110</td>	C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	170	110
Charpy impact strength -30 °C kJ/m² ISO 179-1eU 70 70 CCharpy notched impact strength 23 °C kJ/m² ISO 179-1eA 10 15 CCharpy notched impact strength -30 °C kJ/m² ISO 179-1eA 10 15 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 85 Izod impact strength -30 °C kJ/m² ISO 180-1U 70 65 Izod notched impact strength 23 °C kJ/m² ISO 180-1U 70 65 Izod notched impact strength 23 °C kJ/m² ISO 180-1U 70 65 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 10 10 Flexural strength 20 °C KJ/m² ISO 178-A 10000 5900 Flexural strength 2 mm/min MPa ISO 178-A 3.7 5 Flexural strength 2 mm/min MPa	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 10 15 C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA <10	C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	80	90
C Charpy notched impact strength -30 °C kJ/m² ISO 179-1eA <10 10 Izod impact strength 23 °C kJ/m² ISO 180-1U 75 85 Izod impact strength -30 °C kJ/m² ISO 180-1L 75 85 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 10 10 Flexural strength -30 °C kJ/m² ISO 180-1A 10 10 Flexural strength 2 mm/min MPa ISO 178-A 10000 5900 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 260 160 Thermal properties C ISO 11357-1,-3 220 160 120 °C/h °C ISO 11357-1,-2 200 160 Vicat softening temperature 10 °C/min °C ISO 11359-1,-2 200 150 75-1,-2 210	C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	70	70
Izod impact strength 23 °C kJ/m² ISO 180-1U 75 85 Izod impact strength -30 °C kJ/m² ISO 180-1U 70 65 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 10 10 Flexural modulus 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 3.7 5 Flexural strength 2 mm/min MPa ISO 178-A 3.7 5 Flexural strength 2 mm/min MPa ISO 178-A 260 160 Thermal properties C ISO 11357-1,-3 220 C C ISO 75-1,-2 200 C CTemperature of deflection under load 1.80 MPa °C ISO 306 >200 C Coefficient of linear thermal expansion, parallel 23 to 55	C Charpy notched impact strength	23 °C	kJ/m²	ISO 179-1eA	10	15
Izod impact strength -30 °C kJ/m² ISO 180-1U 70 65 Izod notched impact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A 10 10 Flexural strength 2 mm/min MPa ISO 178-A 10000 5900 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 260 160 Thermal properties 2 C ISO 11357-1,-3 220 C CTemperature of deflection under load 0.45 MPa °C ISO 75-1,-2 200 C Codeficient of linear thermal expansion, parallel 23 to 55 °C 10°/K ISO 11359-1,-2 0.2 C Codeficient of linear thermal expansion, transverse 23 to 55 °C 10°/K ISO 11359-1,-2 0.2 C Codeficition of linear	C Charpy notched impact strength	-30 °C	kJ/m²	ISO 179-1eA	<10	10
Izod notched impact strength 23 °C kJ/m² ISO 180-1A 13 15 Izod notched impact strength -30 °C kJ/m² ISO 180-1A <10	Izod impact strength	23 °C	kJ/m²	ISO 180-1U	75	85
Izad notched impact strength -30 °C kJ/m² ISO 180-1A <10 10 Flexural modulus 2 mm/min MPa ISO 178-A 10000 5900 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 3.7 5 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.7 5 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 3.7 5 CMelting temperature 10 °C/min °C ISO 11357-1,-3 220 C CTemperature of deflection under load 1.80 MPa °C ISO 75-1,-2 200 C CTemperature of deflection under load 0.45 MPa °C ISO 306 >200 C Coefficient of linear thermal expansion, parallel 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 °/K ISO 62 6.5 CWater absorption (Saturation value) <td>Izod impact strength</td> <td>-30 °C</td> <td>kJ/m²</td> <td>ISO 180-1U</td> <td>70</td> <td>65</td>	Izod impact strength	-30 °C	kJ/m²	ISO 180-1U	70	65
Flexural modulus 2 mm/min MPa ISO 178-A 10000 5900 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strength 2 mm/min MPa ISO 178-A 3.7 5 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 260 160 Thermal properties C ISO 178-A 260 160 Thermal properties C ISO 178-A 260 160 CTemperature of deflection under load 1.80 MPa °C ISO 75-1,-3 220 CTemperature of deflection under load 0.45 MPa °C ISO 75-1,-2 210 Vicat softening temperature 50 N; 120 °C/h °C ISO 306 >200 CCoefficient of linear thermal expansion, parallel 23 to 55 °C 10 ⁴ /K ISO 11359-1,-2 0.2 C Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 ⁴ /K ISO 62 6.5 C Wate	Izod notched impact strength	23 °C	kJ/m²	ISO 180-1A	13	15
Flexural strength 2 mm/min MPa ISO 178-A 270 170 Flexural strain at flexural strength 2 mm/min % ISO 178-A 3.7 5 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 2.60 160 Thermal properties 200 170 C Melting temperature 10 °C/min °C ISO 178-A 260 160 Thermal properties 100°C/min °C ISO 178-A 200 C Temperature of deflection under load 1.80 MPa °C ISO 75-1,-2 200 200 C Temperature of deflection under load 0.45 MPa °C ISO 306 >200 200 <td>Izod notched impact strength</td> <td>-30 °C</td> <td>kJ/m²</td> <td>ISO 180-1A</td> <td><10</td> <td>10</td>	Izod notched impact strength	-30 °C	kJ/m²	ISO 180-1A	<10	10
Flexural strain at flexural strength 2 mm/min % ISO 178-A 3.7 5 Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 260 160 Thermal properties 200 160 CMelting temperature 10 °C/min °C ISO 178-A 260 160 CTemperature of deflection under load 1.80 MPa °C ISO 175-1,-2 200 200 CTemperature of deflection under load 0.45 MPa °C ISO 306 >200 200 <td>Flexural modulus</td> <td>2 mm/min</td> <td>MPa</td> <td>ISO 178-A</td> <td>10000</td> <td>5900</td>	Flexural modulus	2 mm/min	MPa	ISO 178-A	10000	5900
Flexural stress at 3.5 % strain 2 mm/min MPa ISO 178-A 260 160 Thermal properties CMelting temperature 10 °C/min °C ISO 11357-1,-3 220 CTemperature of deflection under load 1.80 MPa °C ISO 75-1,-2 200 CTemperature of deflection under load 0.45 MPa °C ISO 75-1,-2 210 Vicat softening temperature 50 N; 120 °C/h °C ISO 306 >200 CCoefficient of linear thermal expansion, parallel 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 CCoefficient of linear thermal expansion, transverse 23 to 55 °C 10 °/K ISO 62 6.5 Other properties (23 °C) Vater at 23 °C % ISO 62 1.9 CDensity Water at 23 °C % ISO 62 1.9 CDensity kg/m³ ISO 1183 1410 Bulk density kg/m³ ISO 60 700 Processing conditions for test specimens C IsO 294 280 C Injection molding-Molt temperature °C ISO 294	Flexural strength	2 mm/min	MPa	ISO 178-A	270	170
Thermal propertiesC Melting temperature10 °C/min°CISO 11357-1,-3220C Temperature of deflection under load1.80 MPa°CISO 75-1,-2200C Temperature of deflection under load0.45 MPa°CISO 75-1,-2210Vicat softening temperature50 N; 120 °C/h°CISO 306>200C Coefficient of linear thermal expansion, parallel23 to 55 °C $10^4/K$ ISO 11359-1,-20.2C Coefficient of linear thermal expansion, transverse23 to 55 °C $10^4/K$ ISO 11359-1,-20.8Other properties (23 °C)C Water absorption (Saturation value)Water at 23 °C%ISO 626.5C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Melt temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations	Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	3.7	5
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,-2 200 C Temperature of deflection under load 0.45 MPa °C ISO 75-1,-2 210 Vicat softening temperature 50 N; 120 °C/h °C ISO 306 >200 C Coefficient of linear thermal expansion, parallel 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 C Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 C Water absorption (Saturation value) Water at 23 °C % ISO 62 6.5 C Water absorption (Equilibrium value) 23 °C; 50 % RH % ISO 62 1.9 C Density kg/m³ ISO 1183 1410 Bulk density kg/m³ ISO 60 700 Processing conditions for test specimens °C ISO 294 280 C Injection molding-Molt temperature °C ISO 294 80	Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	260	160
C Temperature of deflection under load1.80 MPa°CISO 75-1,-2200C Temperature of deflection under load0.45 MPa°CISO 75-1,-2210Vicat softening temperature50 N; 120 °C/h°CISO 306>200C Coefficient of linear thermal expansion, parallel23 to 55 °C 10^4 /KISO 11359-1,-20.2C Coefficient of linear thermal expansion, transverse23 to 55 °C 10^4 /KISO 11359-1,-20.8Other properties (23 °C)C Water absorption (Saturation value)Water at 23 °C%ISO 626.5C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Melt temperature°CISO 294280Processing recommendations°CISO 29480	Thermal properties					
C Temperature of deflection under load 0.45 MPa °C ISO 75-1,-2 210 Vicat softening temperature 50 N; 120 °C/h °C ISO 306 >200 C Coefficient of linear thermal expansion, parallel 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 C Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 °/K ISO 11359-1,-2 0.2 C Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 °/K ISO 11359-1,-2 0.8 Other properties (23 °C) C 10 °/K ISO 62 6.5 C Water absorption (Saturation value) Water at 23 °C % ISO 62 1.9 C Density kg/m³ ISO 62 1.9 1.9 C Injection molding-Melt temperature °C ISO 294 280 C Injection molding-Mold temperature °C ISO 294 80	C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	220	
Vicat softening temperature50 N; 120 °C/h°CISO 306>200C Coefficient of linear thermal expansion, parallel23 to 55 °C10 4/KISO 11359-1,-20.2C Coefficient of linear thermal expansion, transverse23 to 55 °C10 4/KISO 11359-1,-20.2C Coefficient of linear thermal expansion, transverse23 to 55 °C10 4/KISO 11359-1,-20.2Other properties (23 °C)C0000C Water absorption (Saturation value)Water at 23 °C%ISO 626.5C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Mold temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations	C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	200	
C Coefficient of linear thermal expansion, parallel 23 to 55 °C 10 ⁴ /K ISO 11359-1,-2 0.2 C Coefficient of linear thermal expansion, transverse 23 to 55 °C 10 ⁴ /K ISO 11359-1,-2 0.8 Other properties (23 °C) C 10 ⁴ /K ISO 62 6.5 C Water absorption (Saturation value) Water at 23 °C % ISO 62 1.9 C Density kg/m³ ISO 62 1.9 C Density kg/m³ ISO 60 700 Processing conditions for test specimens °C ISO 294 280 C Injection molding-Mold temperature °C ISO 294 80 Processing recommendations °C ISO 294 80	C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	210	
C Coefficient of linear thermal expansion, transverse23 to 55 °C10 4/KISO 11359-1,-20.8Other properties (23 °C)C Water absorption (Saturation value)Water at 23 °C%ISO 626.5C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Melt temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations°CISO 29480	Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	>200	
Other properties (23 °C) Vater at 23 °C % ISO 62 6.5 C Water absorption (Saturation value) 23 °C; 50 % RH % ISO 62 1.9 C Density kg/m³ ISO 60 700 Processing conditions for test specimens °C ISO 294 280 C Injection molding-Melt temperature °C ISO 294 80 Processing recommendations °C ISO 294 80	C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ^{-₄} /K	ISO 11359-1,-2	0.2	
C Water absorption (Saturation value)Water at 23 °C%ISO 626.5C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Melt temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations	C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.8	
C Water absorption (Equilibrium value)23 °C; 50 % RH%ISO 621.9C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensC Injection molding-Melt temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations	Other properties (23 °C)					
C Densitykg/m³ISO 11831410Bulk densitykg/m³ISO 60700Processing conditions for test specimensCISO 294280C Injection molding-Melt temperature°CISO 294280C Injection molding-Mold temperature°CISO 29480Processing recommendations	C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	6.5	
Bulk density kg/m³ ISO 60 700 Processing conditions for test specimens C ISO 294 280 C Injection molding-Melt temperature °C ISO 294 280 C Injection molding-Mold temperature °C ISO 294 80 Processing recommendations V	C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	1.9	
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 Processing recommendations Processing recommendations	C Density	,	kg/m³	ISO 1183	1410	
C Injection molding-Melt temperature °C ISO 294 280 C Injection molding-Mold temperature °C ISO 294 80 Processing recommendations	Bulk density		kg/m³	ISO 60	700	
C Injection molding-Mold temperature °C ISO 294 80 Processing recommendations	Processing conditions for test specimens					
Processing recommendations	C Injection molding-Melt temperature		°C	ISO 294	280	
	C Injection molding-Mold temperature		°C	ISO 294	80	
Drying temperature dry air dryer °C - 80	Processing recommendations					
	Drying temperature dry air dryer		°C	-	80	



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Property	Test Condition	Unit	Standard	guide value d.a.m. cond.
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

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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