

PENTAMID A GV25 MC25 H natural

Polyamide 66
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 66, 25% glass fiber and 25% mineral reinforced

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
	Mineral filler, 25% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Water Absorption			ISO 62
Saturated, 23°C	4.3	%	ISO 62
Equilibrium, 23°C, 50% RH	1.7	%	ISO 62
Viscosity Number	140	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	17000	MPa	ISO 527-2/1
Tensile Stress (Break)	180	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	255	°C	ISO 75-2/B
1.8 MPa, not annealed	250	°C	ISO 75-2/A
Melting Temperature	260	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	75	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.50		IEC 60250
Comparative Tracking Index	450	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.2 mm)	HB		UL 94

Additional Information	Nominal Value	Test Method
ISO Shortname	PA66, MHR, 14-170 N, GF25+MD25	ISO 1874
Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.030 - 0.11	%
Suggested Max Regrind	20	%
Rear Temperature	280 - 305	°C
Middle Temperature	285 - 315	°C
Front Temperature	290 - 305	°C
Processing (Melt) Temp	280 - 310	°C
Mold Temperature	60 - 100	°C
Injection Pressure	90.0	MPa
Screw L/D Ratio	18.0:1.0 to 22.0:1.0	
Screw Compression Ratio	2.2:1.0 to 2.8:1.0	

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