

PENTAMID B GV10 MC20 H2 LS black

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, high heat stabilised polyamide 6, 10% glass fiber and 20% mineral reinforced, laser markable

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 10% filler by weight Mineral filler, 20% filler by weight		
Additive		heat stabilizer		
Features		Laser marking Heat resistance, high Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.80	--	%	ISO 294-4
Flow	0.50	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.7	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8200	5700	MPa	ISO 527-2/1
Tensile Stress (Break)	110	70.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.5	4.5	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	65	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	220	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Flammability	Dry	Conditioned		Test Method
Flame Rating				UL 94
1.6 mm	HB	--		UL 94
3.2 mm	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA6, MHRC, 14-080, GF10+MD20 X			ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.050 - 0.13		%	
Suggested Max Regrind	20		%	
Rear Temperature	265 - 280		°C	
Middle Temperature	275 - 300		°C	
Front Temperature	280 - 290		°C	
Processing (Melt) Temp	260 - 300		°C	
Mold Temperature	40 - 60		°C	
Injection Pressure	72.0		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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