

PENTAMID B MK15 H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 15% mineral filled

General Information				
Filler / Reinforcement		Mineral filler, 15% filler by weight		
Additive		heat stabilizer		
Features		Good dimensional stability		
		Low warpage		
		Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	1.3	--	%	ISO 294-4
Flow direction	1.3	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.2	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	160	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3500	1800	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	55.0	MPa	ISO 527-2
Tensile Strain (Break)	10	25	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	190	--	°C	ISO 75-2/B

1.8 MPa, not annealed	90.0	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	500	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.20 mm)	HB	--		UL 94
Additional Information				
干燥 ISO Description: PA6I, MHRC, 14-040 N, MD15The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.				
调节后的 ISO Description: PA6I, MHRC, 14-040 N, MD15Tensile Strain at Break, ISO 527: >25%				
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.12		%	
Suggested Max Regrind	20		%	
Rear Temperature	250 - 275		°C	
Middle Temperature	265 - 280		°C	
Front Temperature	265 - 275		°C	
Processing (Melt) Temp	270		°C	
Mold Temperature	80.0		°C	
Injection Pressure	55.0		MPa	
Holding Pressure	33.0		MPa	
Screw L/D Ratio	20.0:1.0			
Screw Compression Ratio	2.2:1.0 to 2.8:1.0			

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