

PENTAMID B MK15 E H black

Polyamide 6
PENTAC Polymer GmbH

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

General Information				
Filler / Reinforcement		Mineral filler, 15% filler by weight		
Additive		Impact modifier heat stabilizer		
Features		Impact modification Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.19	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.2	--	%	ISO 294-4
Flow	1.2	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.9	--	%	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	3100	1700	MPa	ISO 527-2/1
Tensile Stress				
Yield	65.0	50.0	MPa	ISO 527-2/50
Fracture	53.0	--	MPa	ISO 527-2/5
Tensile Strain				
Yield	4.0	6.0	%	ISO 527-2/50
Fracture	> 25	> 25	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	8.0	--	kJ/m ²	ISO 179/1eA
23°C	15	20	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	--		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	180	--	°C	ISO 75-2/B
1.8 MPa, not annealed	80.0	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	450	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm)	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA6-HI, MHRC, 14-030 N, MD15-			ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.070 - 0.15		%	
Suggested Max Regrind	20		%	
Rear Temperature	255 - 275		°C	
Middle Temperature	260 - 285		°C	
Front Temperature	265 - 275		°C	
Processing (Melt) Temp	255 - 285		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	60.0		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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