

PENTAMID B GV10 MC20 H schwarz

Polyamide 6
PENTAC Polymer GmbH

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

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 10% filler by weight Mineral filler, 20% filler by weight		
Additive		heat stabilizer		
Features		Thermal Stability Excellent appearance		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
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
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	175	--	MPa	ISO 2039-1
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
Tensile Strain (Break)	3.5	4.5	%	ISO 527-2
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 (DSC)	222	--	°C	ISO 3146

Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	60	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.50	--		IEC 60250
Comparative Tracking Index	450	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.20 mm)	HB	--		UL 94
Additional Information				

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ISO Description: PA6, MHRC, 14-080 N, GF10+MD20The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHRC, 14-080 N, GF10+MD20

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.090	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 280	°C
Middle Temperature	280 - 295	°C
Front Temperature	280 - 290	°C
Processing (Melt) Temp	280	°C
Mold Temperature	80.0	°C
Injection Pressure	70.0	MPa
Holding Pressure	42.0	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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