# PENTAMID A GK30 H LS black

Polyamide 66

PENTAC Polymer GmbH

## Message:

Normal viscosity, heat stabilised polyamide 66, 30% glass bead reinforced, laser markable

| General Information | | | | |
|---|---|---|---|---|
| Filler / Reinforcement | Glass beads, 30% filler by weight | | | |
| Additive | heat stabilizer | | | |
| Features | Laser marking<br>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/cm³ | ISO 1183 |
| Molding Shrinkage | | | | ISO 294-4 |
| Transverse flow | 0.90 | -- | % | ISO 294-4 |
| Flow | 0.90 | -- | % | ISO 294-4 |
| Water Absorption | | | | ISO 62 |
| Saturated, 23°C | 5.2 | -- | % | ISO 62 |
| Equilibrium, 23°C, 50% RH | 1.6 | -- | % | ISO 62 |
| Viscosity Number | 140 | -- | cm³/g | ISO 307 |
| **Mechanical** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Tensile Modulus | 4500 | 2300 | MPa | ISO 527-2/1 |
| Tensile Stress (Break) | 75.0 | 55.0 | MPa | ISO 527-2/5 |
| Tensile Strain (Break) | 6.0 | > 25 | % | ISO 527-2/5 |
| **Impact** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength (23°C) | 5.0 | 7.0 | kJ/m² | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 40 | 80 | kJ/m² | ISO 179/1eU |
| **Thermal** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Heat Deflection Temperature | | | | |
| 0.45 MPa, not annealed | 195 | -- | °C | ISO 75-2/B |
| 1.8 MPa, not annealed | 80.0 | -- | °C | ISO 75-2/A |
| Melting Temperature | 260 | -- | °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 | PA66, MHRC 14-050 N, GB30 X-- | | ISO 1874 |

| Injection | Dry | Unit |
|---|---|---|
| Drying Temperature | 80 | °C |
| Drying Time | 3.0 | hr |
| Suggested Max Moisture | 0.050 - 0.13 | % |
| Suggested Max Regrind | 20 | % |
| Rear Temperature | 270 - 290 | °C |
| Middle Temperature | 275 - 300 | °C |
| Front Temperature | 280 - 290 | °C |
| Processing (Melt) Temp | 270 - 300 | °C |
| Mold Temperature | 60 - 100 | °C |
| Injection Pressure | 78.0 | 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 | |



## Recommended distributors for this material

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