PENTAMID AB S GVB16 H black

Polyamide 66/6 Copolymer

PENTAC Polymer GmbH

Message:

Low viscosity, heat stabilised polyamide 66+6, glass fiber and glass bubbles reinforced

General Information			
Filler / Reinforcement	Micro glass bead \glass fiber, 16% filler by weight		
Additive	heat stabilizer		
Features	Low viscosity Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.16	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.85	%	ISO 294-4
Flow	0.50	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	7.1	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	ISO 62
Viscosity Number	125	cm³/g	ISO 307
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	5900	MPa	ISO 527-2/1
Tensile Stress (Break)	110	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	3.5	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	26	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	235	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°C	ISO 75-2/A
Melting Temperature	255	°C	ISO 11357-3
Flammability	**Nominal Value**		**Test Method**
Flame Rating (3.2 mm)	HB		UL 94
Additional Information	**Nominal Value**		**Test Method**

ISO Shortname	PA66 + 6, MHRC, 12-060, (GF+ GB) 16, X	ISO 1874
Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.030 - 0.11	%
Suggested Max Regrind	20	%
Rear Temperature	280 - 300	°C
Middle Temperature	285 - 310	°C
Front Temperature	290 - 300	°C
Processing (Melt) Temp	280 - 310	°C
Mold Temperature	60 - 100	°C
Injection Pressure	90.0	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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