

PENTAMID B GV60 H natural

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 60% glass fiber reinforced

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 60% filler by weight			
Additive	heat stabilizer			
Features	Thermal Stability			
Agency Ratings	EC 1907/2006 (REACH)			
Appearance	Natural color			
Forms	Particle			
Processing Method	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.68	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.35	--	%	ISO 294-4
Flow	0.20	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	4.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	18900	--	MPa	ISO 527-2/1
Tensile Stress (Break)	220	--	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	--	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	22	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	100	100	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	215	--	°C	ISO 75-2/A
Melting Temperature	222	--	°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	PA6, MHR, 14-190 N, GF60	--	ISO 1874
Injection	Dry	Unit	
Drying Temperature	80		°C
Drying Time	3.0		hr
Suggested Max Moisture	0.030 - 0.11		%
Suggested Max Regrind	20		%
Rear Temperature	275 - 295		°C
Middle Temperature	280 - 305		°C
Front Temperature	285 - 295		°C
Processing (Melt) Temp	270 - 310		°C
Mold Temperature	60 - 100		°C
Injection Pressure	82.5		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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