

PENTAMID AB GV50 H black

Polyamide 66/6 Copolymer

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 66+6, 50% glass fiber reinforced

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight			
Additive	heat stabilizer			
Features	Thermal Stability			
Agency Ratings	EC 1907/2006 (REACH)			
Appearance	Black			
Forms	Particle			
Processing Method	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.56	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.40	--	%	ISO 294-4
Flow	0.20	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	4.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.5	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	17000	12400	MPa	ISO 527-2/1
Tensile Stress (Break)	230	160	MPa	ISO 527-2/5
Tensile Strain (Break)	2.4	3.9	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	20	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	85	90	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	--	°C	ISO 75-2/A
Melting Temperature	260	--	°C	ISO 11357-3
Flammability	Dry	Conditioned	Test Method	
Flame Rating (1.6 mm)	HB	--	UL 94	
Additional Information	Dry	Conditioned	Test Method	
ISO Shortname	PA66 + PA6, MHRC, 14-160, GF50			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	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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