

PENTAMID AB S GV30 H natural

Polyamide 66/6 Copolymer

PENTAC Polymer GmbH

Message:

Low viscosity, heat stabilised polyamide 66+6, 30% glass fiber reinforced

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Low viscosity		
	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.65	%	ISO 294-4
Flow	0.35	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	5.4	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ISO 62
Viscosity Number	125	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10700	MPa	ISO 527-2/1
Tensile Stress (Break)	170	MPa	ISO 527-2/5
Tensile Strain (Break)	2.4	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	65	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	250	°C	ISO 75-2/B
1.8 MPa, not annealed	235	°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+PA6, MHR, 12-100 N, GF30	ISO 1874
Injection	Nominal Value	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	265 - 305	°C
Mold Temperature	60 - 100	°C
Injection Pressure	72.0	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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

