

PENTAMID B MK40 H natural

Polyamide 6

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 6, 40% mineral filled

General Information				
Filler / Reinforcement	Mineral filler, 40% 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	1.46	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.65	--	%	ISO 294-4
Flow	0.60	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.1	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5750	2250	MPa	ISO 527-2/1
Tensile Stress (Break)	85.0	55.0	MPa	ISO 527-2/5
Tensile Strain (Break)	5.0	14	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	80	95	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	200	--	°C	ISO 75-2/B
1.8 MPa, not annealed	100	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	32	--	kV/mm	IEC 60243-1

Dielectric Constant (1 MHz)	3.50	--		IEC 60250
Comparative Tracking Index	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm)	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA6, MHR, 14-060 N, MD40	--		ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.040 - 0.12		%	
Suggested Max Regrind	20		%	
Rear Temperature	265 - 285		°C	
Middle Temperature	270 - 295		°C	
Front Temperature	275 - 285		°C	
Processing (Melt) Temp	260 - 300		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	74.0		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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