

# PENTAMID A GV20 GK10 H natural

Polyamide 66  
PENTAC Polymer GmbH

Message:  
Normal viscosity, heat stabilised polyamide 66, 30% glass fiber and bead reinforced, special coloration

| General Information                     |      |                                                                                            |                    |             |
|-----------------------------------------|------|--------------------------------------------------------------------------------------------|--------------------|-------------|
| Filler / Reinforcement                  |      | Glass fiber reinforced material, 20% filler by weight<br>Glass beads, 10% 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                                 | 1.36 | --                                                                                         | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                       |      |                                                                                            |                    | ISO 294-4   |
| Transverse flow                         | 0.70 | --                                                                                         | %                  | ISO 294-4   |
| Flow                                    | 0.40 | --                                                                                         | %                  | ISO 294-4   |
| Water Absorption                        |      |                                                                                            |                    | ISO 62      |
| Saturated, 23°C                         | 5.2  | --                                                                                         | %                  | ISO 62      |
| Equilibrium, 23°C, 50% RH               | 1.8  | --                                                                                         | %                  | ISO 62      |
| Viscosity Number                        | 140  | --                                                                                         | cm <sup>3</sup> /g | ISO 307     |
| Mechanical                              | Dry  | Conditioned                                                                                | Unit               | Test Method |
| Tensile Modulus                         | 7600 | 5050                                                                                       | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                  | 160  | 110                                                                                        | MPa                | ISO 527-2/5 |
| Tensile Strain (Break)                  | 3.5  | 5.0                                                                                        | %                  | ISO 527-2/5 |
| Impact                                  | Dry  | Conditioned                                                                                | Unit               | Test Method |
| Charpy Notched Impact Strength (23°C)   | 8.0  | 12                                                                                         | kJ/m <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 50   | 70                                                                                         | kJ/m <sup>2</sup>  | ISO 179/1eU |
| Thermal                                 | Dry  | Conditioned                                                                                | Unit               | Test Method |
| Heat Deflection Temperature             |      |                                                                                            |                    |             |
| 0.45 MPa, not annealed                  | 230  | --                                                                                         | °C                 | ISO 75-2/B  |
| 1.8 MPa, not annealed                   | 205  | --                                                                                         | °C                 | ISO 75-2/A  |
| Melting Temperature                     | 260  | --                                                                                         | °C                 | ISO 11357-3 |

| Electrical                  | Dry                             | Conditioned | Unit  | Test Method |
|-----------------------------|---------------------------------|-------------|-------|-------------|
| Dielectric Strength         | 32                              | --          | kV/mm | IEC 60243-1 |
| Dielectric Constant (1 MHz) | 3.40                            | --          |       | IEC 60250   |
| Comparative Tracking Index  | 600                             | --          | 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               | PA66, MHRC, 14-080 N, (GF+GB)30 |             |       | ISO 1874    |
| Injection                   | Dry                             | 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          | 65.0                            |             | 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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