PENTAMID B S GV50 H black

Polyamide 6

PENTAC Polymer GmbH

Message:

Low viscosity, heat stabilised polyamide 6, 50% glass fiber reinforced

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight			
Additive	heat stabilizer			
Features	Low viscosity 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/cm³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.40	--	%	ISO 294-4
Flow	0.25	--	%	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	120	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	15400	11000	MPa	ISO 527-2/1
Tensile Stress (Break)	210	145	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	3.6	%	ISO 527-2/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	17	24	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	85	100	kJ/m²	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	210	--	°C	ISO 75-2/A
Melting Temperature	221	--	°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, MHRC, 12-160, GF50	--	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	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	71.5	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	

Recommended distributors for this material

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