

PENTAMID B S GV15 H natural

Polyamide 6
PENTAC Polymer GmbH

Message:
Low viscosity, heat stabilised polyamide 6, 15% glass fiber reinforced

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% 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	Dry	Conditioned	Unit	Test Method
Density	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.85	--	%	ISO 294-4
Flow	0.65	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	8.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	--	%	ISO 62
Viscosity Number	125	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6200	3200	MPa	ISO 527-2/1
Tensile Stress (Break)	125	75.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.8	11	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	75	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	210	--	°C	ISO 75-2/B
1.8 MPa, not annealed	195	--	°C	ISO 75-2/A
Melting Temperature	222	--	°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, MHR, 12-060, GF15	--	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		

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