

PENTAMID A CV10 H black

Polyamide 66
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 66, 10% carbon fiber reinforced

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.50	%	ISO 294-4
Flow	0.35	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	7.8	%	ISO 62
Equilibrium, 23°C, 50% RH	2.6	%	ISO 62
Viscosity Number	140	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9900	MPa	ISO 527-2/1
Tensile Stress (Break)	145	MPa	ISO 527-2/5
Tensile Strain (Break)	1.8	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	34	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	255	°C	ISO 75-2/B
1.8 MPa, not annealed	240	°C	ISO 75-2/A
Melting Temperature	260	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.6 mm	HB		UL 94
3.2 mm	HB		UL 94
Additional Information	Nominal Value		Test Method

ISO Shortname	PA66, MHRC, 14-90 N, CF10	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	265 - 290	°C
Middle Temperature	275 - 300	°C
Front Temperature	280 - 290	°C
Processing (Melt) Temp	270 - 300	°C
Mold Temperature	60 - 100	°C
Injection Pressure	78.0	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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