

PENTAMID A SK H schwarz

Polyamide 66
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 66, short cycle time

General Information				
Additive	heat stabilizer			
Features	Fast molding cycle			
	Thermal Stability			
Uses	Handle			
	Furniture			
	Connector			
Agency Ratings	EC 1907/2006 (REACH)			
Appearance	Black			
Forms	Particle			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	1.9	--	%	ISO 294-4
Flow direction	1.9	--	%	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
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	165	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3200	1250	MPa	ISO 527-2/1
Tensile Stress				ISO 527-2
Yield	90.0	55.0	MPa	ISO 527-2
Fracture	--	55.0	MPa	ISO 527-2
Tensile Strain				ISO 527-2
Yield	4.0	15	%	ISO 527-2
Fracture	--	50	%	ISO 527-2
Flexural Modulus	3100	--	MPa	ISO 178
Flexural Stress	120	--	MPa	ISO 178

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		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	75.0	--	°C	ISO 75-2/A
Melting Temperature (DSC)	260	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	30	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.20	--		IEC 60250
Comparative Tracking Index	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	V-2	--		UL 94
3.20 mm	V-2	--		UL 94

Additional Information

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ISO Description: PA66, MHRC, 14-030 NThe value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA66, MHRC, 14-030 NTensile Strain at Break, ISO 527: >50%

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.14	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 285	°C
Middle Temperature	275 - 290	°C
Front Temperature	275 - 285	°C
Processing (Melt) Temp	280	°C
Mold Temperature	80.0	°C
Injection Pressure	60.0	MPa
Holding Pressure	36.0	MPa
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.2:1.0 to 2.8:1.0	

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