

PENTAMID AB GV15 E H natur

Polyamide 66/6 Copolymer

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 66+6, 15% glass fiber reinforced, impact modified

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Additive		Impact modifier		
		heat stabilizer		
Features		Impact modification		
		Rigid, good		
		Impact resistance, good		
		Thermal Stability		
Uses		Sporting goods		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.21	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.70	--	%	ISO 294-4
Flow direction	0.50	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.6	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.3	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	170	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5200	2600	MPa	ISO 527-2/1
Tensile Stress (Break)	105	60.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	15	%	ISO 527-2
Flexural Modulus	4750	--	MPa	ISO 178
Flexural Stress	165	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method

Charpy Notched Impact Strength (23°C)	19	23	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	75	85	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	205	--	°C	ISO 75-2/B
1.8 MPa, not annealed	185	--	°C	ISO 75-2/A
Melting Temperature (DSC)	255	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	32	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.30	--		IEC 60250
Comparative Tracking Index	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.20 mm)	HB	--		UL 94
Additional Information				

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ISO Description: PA66+6-HI, MHR, 14-050 N, GF15The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA66+6-HI, MHR, 14-050 N, GF15

Injection	Dry	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.11	%	
Suggested Max Regrind	20	%	
Rear Temperature	265 - 290	°C	
Middle Temperature	280 - 295	°C	
Front Temperature	280 - 290	°C	
Processing (Melt) Temp	285	°C	
Mold Temperature	80.0	°C	
Injection Pressure	60.0	MPa	
Holding Pressure	33.0	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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