

PENTAMID L GV25 H black

Polyamide 12
PENTAC Polymer GmbH

Message:
Normal viscosity, 25% glass fiber reinforced polyamide 12, heat stabilised

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 25% filler by weight		
Additive		heat stabilizer		
Features		Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.19	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.70	--	%	ISO 294-4
Flow	0.30	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	1.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	0.50	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5800	5000	MPa	ISO 527-2/1
Tensile Stress (Break)	110	95.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	--	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	--	70	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	150	--	°C	ISO 75-2/A
Melting Temperature	178	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	35	--	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.40	--		IEC 60250
Comparative Tracking Index	600	--	V	IEC 60112

Flammability	Dry	Conditioned	Unit	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	PA12, MHRC, 16-060, GF25	--		ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.0 - 0.080		%	
Suggested Max Regrind	20		%	
Rear Temperature	245 - 270		°C	
Middle Temperature	255 - 280		°C	
Front Temperature	260 - 270		°C	
Processing (Melt) Temp	245 - 285		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	65.0		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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