

# PENTAMID B L10 H RC schwarz

Polyamide 6  
PENTAC Polymer GmbH

Message:  
Normal viscosity, high impact modified, heat stabilised polyamide 6, Recompound

| General Information                  |      |                                          |                    |             |
|--------------------------------------|------|------------------------------------------|--------------------|-------------|
| Additive                             |      | Impact modifier<br>heat stabilizer       |                    |             |
| Recycled Content                     |      | Yes                                      |                    |             |
| Features                             |      | Impact modification<br>Thermal Stability |                    |             |
| Uses                                 |      | Safety equipment<br>Sporting goods       |                    |             |
| Agency Ratings                       |      | EC 1907/2006 (REACH)                     |                    |             |
| Appearance                           |      | Black                                    |                    |             |
| Forms                                |      | Particle                                 |                    |             |
| Physical                             | Dry  | Conditioned                              | Unit               | Test Method |
| Density                              | 1.10 | --                                       | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                    |      |                                          |                    | ISO 294-4   |
| Vertical flow direction              | 2.0  | --                                       | %                  | ISO 294-4   |
| Flow direction                       | 1.6  | --                                       | %                  | ISO 294-4   |
| Water Absorption                     |      |                                          |                    | ISO 62      |
| Saturated, 23°C                      | 8.9  | --                                       | %                  | ISO 62      |
| Equilibrium, 23°C, 50% RH            | 2.5  | --                                       | %                  | ISO 62      |
| Viscosity Number                     | 145  | --                                       | cm <sup>3</sup> /g | ISO 307     |
| Hardness                             | Dry  | Conditioned                              | Unit               | Test Method |
| Ball Indentation Hardness (H 358/30) | 120  | --                                       | MPa                | ISO 2039-1  |
| Mechanical                           | Dry  | Conditioned                              | Unit               | Test Method |
| Tensile Modulus                      | 2400 | 1000                                     | MPa                | ISO 527-2/1 |
| Tensile Stress (Yield)               | 60.0 | 45.0                                     | MPa                | ISO 527-2   |
| Tensile Strain (Yield)               | 7.0  | 20                                       | %                  | ISO 527-2   |
| Flexural Modulus                     | 2200 | --                                       | MPa                | ISO 178     |
| Flexural Stress                      | 90.0 | --                                       | MPa                | ISO 178     |
| Impact                               | Dry  | Conditioned                              | Unit               | Test Method |

|                                         |          |             |                   |             |
|-----------------------------------------|----------|-------------|-------------------|-------------|
| Charpy Notched Impact Strength (23°C)   | 15       | 45          | kJ/m <sup>2</sup> | 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                  | 175      | --          | °C                | ISO 75-2/B  |
| 1.8 MPa, not annealed                   | 65.0     | --          | °C                | ISO 75-2/A  |
| Melting Temperature (DSC)               | 222      | --          | °C                | ISO 3146    |
| Electrical                              | Dry      | Conditioned | Unit              | Test Method |
| Dielectric Strength (1.00 mm)           | 35       | --          | kV/mm             | IEC 60243-1 |
| Relative Permittivity (1 MHz)           | 3.50     | --          |                   | IEC 60250   |
| Comparative Tracking Index              | 500      | --          | V                 | IEC 60112   |
| Flammability                            | Dry      | Conditioned | Unit              | Test Method |
| Flame Rating                            |          |             |                   | UL 94       |
| 1.60 mm                                 | HB       | --          |                   | UL 94       |
| 3.20 mm                                 | HB       | --          |                   | UL 94       |

#### Additional Information

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ISO Description: PA6-HI, MHRC, 14-020The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA6-HI, MHRC, 14-020

|                         |                    |      |  |
|-------------------------|--------------------|------|--|
| Injection               | Dry                | Unit |  |
| Drying Temperature      | 70.0               | °C   |  |
| Drying Time             | 3.0                | hr   |  |
| Suggested Max Moisture  | 0.14               | %    |  |
| Suggested Max Regrind   | 20                 | %    |  |
| Rear Temperature        | 250 - 275          | °C   |  |
| Middle Temperature      | 265 - 280          | °C   |  |
| Front Temperature       | 265 - 275          | °C   |  |
| Processing (Melt) Temp  | 270                | °C   |  |
| Mold Temperature        | 80.0               | °C   |  |
| Injection Pressure      | 55.0               | 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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