

PENTALLOY BP H natural

Polyamide 6 + PP
PENTAC Polymer GmbH

Message:
PA6+PP-alloy, non-reinforced, heat stabilised, resistant to corrosion

General Information				
Additive		heat stabilizer		
Features		Good corrosion resistance		
		Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.04	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.8	--	%	ISO 294-4
Flow	1.4	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	4.2	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.3	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2800	1800	MPa	ISO 527-2/1
Tensile Stress (Yield)	65.0	50.0	MPa	ISO 527-2/50
Tensile Strain				
Yield	5.0	10	%	ISO 527-2/50
Fracture	> 40	> 40	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	6.0	--	kJ/m ²	ISO 179/1eA
23°C	12	24	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	--		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, not annealed	135	--	°C	ISO 75-2/B
1.8 MPa, not annealed	75.0	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Flammability	Dry	Conditioned		Test Method
Flame Rating				UL 94
1.6 mm	HB	--		UL 94
3.2 mm	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.050 - 0.13		%	
Suggested Max Regrind	20		%	
Rear Temperature	245 - 260		°C	
Middle Temperature	250 - 270		°C	
Front Temperature	265		°C	
Processing (Melt) Temp	240 - 280		°C	
Mold Temperature	40 - 80		°C	
Injection Pressure	72.0		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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