

PENTAMID B S GV10 GK20 H black

Polyamide 6
PENTAC Polymer GmbH

Message:
Low viscosity, heat stabilised polyamide 6, 10% glass fiber and 20% glass bead reinforced

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
	Glass beads, 20% filler by weight		
Additive	heat stabilizer		
Features	Low viscosity		
	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.70	%	ISO 294-4
Flow	0.55	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	6.5	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	ISO 62
Viscosity Number	125	cm³/g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5500	MPa	ISO 527-2/1
Tensile Stress (Break)	100	MPa	ISO 527-2/5
Tensile Strain (Break)	2.9	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	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	222	°C	ISO 11357-3
Flammability	Nominal Value		Test Method

Flame Rating		UL 94
1.6 mm	HB	UL 94
3.2 mm	HB	UL 94
Additional Information	Nominal Value	Test Method
ISO Shortname	PA6, MHRC, 12-060 N, GF10+GB20	ISO 1874
Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.050 - 0.13	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 280	°C
Middle Temperature	265 - 290	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	255 - 295	°C
Mold Temperature	60 - 100	°C
Injection Pressure	71.5	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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