

PENTAMID B GV15 H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 15% glass fiber reinforced

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight		
Additive		Heat Stabilizer		
Features		Good Stiffness		
		Good Surface Finish		
		Heat Stabilized		
Uses		Housings		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural Color		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.95	--	%	
Flow	0.65	--	%	
Water Absorption				ISO 62
Saturation, 23°C	8.0	--	%	
Equilibrium, 23°C, 50% RH	2.5	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	175	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5600	3200	MPa	ISO 527-2/1
Tensile Stress (Break)	120	75.0	MPa	ISO 527-2
Tensile Strain (Break)	3.8	11	%	ISO 527-2
Flexural Modulus	5000	--	MPa	ISO 178
Flexural Stress	170	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	55	80	kJ/m ²	ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	210	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	195	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Electric Strength (1.00 mm)	33	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.80	--		IEC 60250
Comparative Tracking Index	525	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	HB	--		
3.20 mm	HB	--		
Additional Information	Dry	Conditioned		Test Method
ISO Type	PA6, MHR, 14-060, GF15	PA6, MHR, 14-060, GF15		ISO 11357
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.11		%	
Suggested Max Regrind	20		%	
Rear Temperature	255 to 280		°C	
Middle Temperature	270 to 285		°C	
Front Temperature	270 to 280		°C	
Processing (Melt) Temp	275		°C	
Mold Temperature	80.0		°C	
Injection Pressure	62.5		MPa	
Holding Pressure	37.5		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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