

PENTAMID B MA30 T H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 30% mineral filled, good surfaces

General Information				
Filler / Reinforcement		Mineral filler, 30% filler by weight		
Additive		heat stabilizer		
Features		Thermal Stability		
		Excellent appearance		
Uses		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.40	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.80	--	%	ISO 294-4
Flow direction	0.65	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	5.9	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	180	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6200	3200	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	55.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	10	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	35	60	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	190	--	°C	ISO 75-2/B

1.8 MPa, not annealed	105	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	30	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.50	--		IEC 60250
Comparative Tracking Index	475	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.20 mm)	HB	--		UL 94
Additional Information				

干燥
ISO Description: PA6, MHR, 14-060 N, MD30The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHR, 14-060 N, MD30

Injection	Dry	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.090	%	
Suggested Max Regrind	20	%	
Rear Temperature	245 - 265	°C	
Middle Temperature	265 - 280	°C	
Front Temperature	265 - 275	°C	
Processing (Melt) Temp	265	°C	
Mold Temperature	80.0	°C	
Injection Pressure	65.0	MPa	
Holding Pressure	39.0	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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