

PENTAMID B MK30 H natur

Polyamide 6
PENTAC Polymer GmbH

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

General Information				
Filler / Reinforcement		Mineral filler, 30% filler by weight		
Additive		heat stabilizer		
Features		Low warpage		
		Rigid, good		
		Thermal Stability		
Uses		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.90	--	%	ISO 294-4
Flow direction	0.80	--	%	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	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	170	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	4200	2200	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	50.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	15	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	15	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	100 kJ/m ²	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	195	--	°C	ISO 75-2/B
1.8 MPa, not annealed	95.0	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	29	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.40	--		IEC 60250
Comparative Tracking Index	550	--	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

干燥
ISO Description: PA6, MHR, 14-040 N, MD30The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHR, 14-040 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	260 - 270	°C	
Middle Temperature	275 - 290	°C	
Front Temperature	275 - 285	°C	
Processing (Melt) Temp	280	°C	
Mold Temperature	80.0	°C	
Injection Pressure	70.0	MPa	
Holding Pressure	42.0	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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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