

PENTAMID AHT H1 ungefärbt

Polyamide 46
PENTAC Polymer GmbH

Message:
Polyamide 4.6

General Information				
Agency Ratings		EC 1907/2006 (REACH)		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.18	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	2.3	--	%	
Flow	2.2	--	%	
Water Absorption				ISO 62
Saturation, 23°C	10	--	%	
Equilibrium, 23°C, 50% RH	3.6	--	%	
Viscosity Number	160	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	170	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3200	1000	MPa	ISO 527-2/1
Tensile Stress (Yield)	100	55.0	MPa	ISO 527-2
Tensile Strain (Yield)	8.0	25	%	ISO 527-2
Flexural Modulus	3250	--	MPa	ISO 178
Flexural Stress	125	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	35	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	285	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	160	--	°C	ISO 75-2/A
Melting Temperature	295	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Electric Strength (1.00 mm)	25	--	kV/mm	IEC 60243-1

Relative Permittivity (1 MHz)	3.50	--		IEC 60250
Comparative Tracking Index	450	--	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	PA46, MHR, 16-030 N	PA46, MHR, 16-030 N		ISO 1874
Injection	Dry	Unit		
Drying Temperature	90.0		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.17		%	
Suggested Max Regrind	20		%	
Rear Temperature	290 to 315		°C	
Middle Temperature	305 to 320		°C	
Front Temperature	305 to 315		°C	
Processing (Melt) Temp	310		°C	
Mold Temperature	100		°C	
Injection Pressure	65.0		MPa	
Holding Pressure	35.8		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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