

PENTALLOY BS 6 GV10 H schwarz

Acrylonitrile Butadiene Styrene + Nylon
PENTAC Polymer GmbH

Message:
PA-ABS alloy, 10% glass fiber reinforced, heat stabilised

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 10% filler by weight		
Additive		heat stabilizer		
Features		Low warpage		
		Low hygroscopicity		
		Thermal Stability		
		Low shrinkage		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.15	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.80	--	%	ISO 294-4
Flow direction	0.55	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	3.2	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	--	%	ISO 62
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	155	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3850	2900	MPa	ISO 527-2/1
Tensile Stress (Break)	65.0	50.0	MPa	ISO 527-2
Tensile Strain (Break)	4.5	7.0	%	ISO 527-2
Flexural Modulus	3600	--	MPa	ISO 178
Flexural Stress	70.0	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	20	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	65	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, not annealed	125	--	°C	ISO 75-2/B
1.8 MPa, not annealed	110	--	°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)	3.10	--		IEC 60250
Comparative Tracking Index	600	--	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				

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The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

Injection	Dry	Unit
Drying Temperature	75.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.11	%
Suggested Max Regrind	20	%
Rear Temperature	250 - 270	°C
Middle Temperature	260 - 275	°C
Front Temperature	260 - 270	°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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