

PENTAMID A GVK33 E H schwarz

Polyamide 66

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 66, 33% glass fiber and bead reinforced, impact modified

General Information				
Filler / Reinforcement		Micro glass bead \glass fiber, 33% filler by weight		
Additive		Impact modifier heat stabilizer		
Features		Impact modification Low warpage Rigidity, high Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.39	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.65	--	%	ISO 294-4
Flow direction	0.45	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	5.1	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.6	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	165	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	7400	4700	MPa	ISO 527-2/1
Tensile Stress (Break)	115	80.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	8.0	%	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)	75	90	kJ/m ²	ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	220	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Melting Temperature (DSC)	260	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	35	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.70	--		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

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ISO Description: PA66-HI, MHRC, 14-070 N, (GF+GB)33XThe value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA66-HI, MHRC, 14-070 N, (GF+GB)33X

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.090	%
Suggested Max Regrind	20	%
Rear Temperature	265 - 290	°C
Middle Temperature	280 - 295	°C
Front Temperature	280 - 290	°C
Processing (Melt) Temp	285	°C
Mold Temperature	80.0	°C
Injection Pressure	80.0	MPa
Holding Pressure	48.0	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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