

PENTAMID B GV50 H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 50% glass fiber reinforced

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 50% filler by weight		
Additive		heat stabilizer		
Features		Thermal Stability		
Uses		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.56	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.40	--	%	ISO 294-4
Flow direction	0.25	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	4.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.5	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	270	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	15000	11000	MPa	ISO 527-2/1
Tensile Stress (Break)	220	150	MPa	ISO 527-2
Tensile Strain (Break)	3.0	4.0	%	ISO 527-2
Flexural Modulus	14000	--	MPa	ISO 178
Flexural Stress	320	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	21	26	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	100	100	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	210	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	35	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.80	--		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, 14-150 N, GF50The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHR, 14-150 N, GF50

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.070	%
Suggested Max Regrind	20	%
Rear Temperature	270 - 295	°C
Middle Temperature	285 - 300	°C
Front Temperature	285 - 295	°C
Processing (Melt) Temp	290	°C
Mold Temperature	80.0	°C
Injection Pressure	82.5	MPa
Holding Pressure	49.5	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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