

PENTAMID B GV15 MK25 H RC black

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 15% glass fiber and 25% mineral reinforced, ReCompound

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight Mineral filler, 25% filler by weight		
Additive		heat stabilizer		
Recycled Content		Yes		
Features		Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.46	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturated, 23°C	5.7	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	--	%	ISO 62
Viscosity Number	132	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	7000	5200	MPa	ISO 527-2/1
Tensile Stress (Break)	110	80.0	MPa	ISO 527-2/5
Tensile Strain (Break)	4.0	6.0	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	46	60	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	210	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	30	--	kV/mm	IEC 60243-1

Dielectric Constant (1 MHz)	3.50	--		IEC 60250
Comparative Tracking Index	400	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm)	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA6, MHRC, 14-070 N, GF15+MD25			ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.050 - 0.13		%	
Suggested Max Regrind	20		%	
Rear Temperature	270 - 290		°C	
Middle Temperature	275 - 300		°C	
Front Temperature	280 - 290		°C	
Processing (Melt) Temp	265 - 305		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	65.0		MPa	
Screw L/D Ratio	18.0:1.0 to 22.0:1.0			
Screw Compression Ratio	2.2:1.0 to 2.8:1.0			

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