

PENTAMID B GK30 H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 30% glass bead reinforced

General Information				
Filler / Reinforcement		Glass beads, 30% filler by weight		
Additive		heat stabilizer		
Features		Good dimensional stability		
		Low warpage		
		Thermal Stability		
Uses		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.80	--	%	ISO 294-4
Flow direction	0.80	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.5	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	170	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	4300	2150	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	55.0	MPa	ISO 527-2
Tensile Strain (Break)	8.0	25	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	9.0	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, not annealed	185	--	°C	ISO 75-2/B
1.8 MPa, not annealed	70.0	--	°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)	3.80	--		IEC 60250
Comparative Tracking Index	500	--	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, 14-040 N, GB30The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHR, 14-040 N, GB30Tensile Strain at Break, ISO 527: >25%

Injection	Dry	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.090	%	
Suggested Max Regrind	20	%	
Rear Temperature	255 - 280	°C	
Middle Temperature	270 - 285	°C	
Front Temperature	270 - 280	°C	
Processing (Melt) Temp	275	°C	
Mold Temperature	80.0	°C	
Injection Pressure	71.5	MPa	
Holding Pressure	42.9	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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