

PENTAMID B MA 25 H schwarz

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 25% mineral filled

General Information				
Filler / Reinforcement		Mineral filler, 25% filler by weight		
Additive		heat stabilizer		
Features		Low warpage		
		Rigid, good		
		Thermal Stability		
Uses		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.70 - 1.0	--	%	ISO 294-4
Flow direction	0.60 - 0.90	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.2	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.3	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	175	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5200	2800	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	50.0	MPa	ISO 527-2
Tensile Strain (Break)	5.5	14	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	55	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	200	--	°C	ISO 75-2/B
1.8 MPa, not annealed	160	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Flammability	Dry	Conditioned		Test Method
Flame Rating (3.20 mm)	HB	--		UL 94

Additional Information

干燥
ISO Description: PA6, MHRC, 14-050 N, MD25The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHRC, 14-050 N, MD25

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.10	%
Suggested Max Regrind	20	%
Rear Temperature	270 - 295	°C
Middle Temperature	285 - 295	°C
Front Temperature	285 - 290	°C
Processing (Melt) Temp	285	°C
Mold Temperature	80.0	°C
Injection Pressure	60.0	MPa
Holding Pressure	36.0	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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