

PENTAMID A MK15 E H schwarz

Polyamide 66
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 66, 15% mineral filled, impact modified

General Information				
Filler / Reinforcement		Mineral filler, 15% filler by weight		
Additive		Impact modifier heat stabilizer		
Features		Good dimensional stability Impact modification Low warpage Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	1.1	--	%	ISO 294-4
Flow direction	1.1	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.0	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	150	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	1500	MPa	ISO 527-2/1
Tensile Stress (Break)	70.0	55.0	MPa	ISO 527-2
Tensile Strain (Break)	15	25	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	19	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	180	--	°C	ISO 75-2/B
1.8 MPa, not annealed	80.0	--	°C	ISO 75-2/A
Melting Temperature (DSC)	260	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	30	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	4.00	--		IEC 60250
Comparative Tracking Index	475	--	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: PA66-HI, MHRC, 14-030 N, MD15The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA66-HI, MHRC, 14-030 N, MD15Tensile Strain at Break, ISO 527: >25%

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.11	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 285	°C
Middle Temperature	275 - 290	°C
Front Temperature	275 - 285	°C
Processing (Melt) Temp	280	°C
Mold Temperature	80.0	°C
Injection Pressure	70.0	MPa
Holding Pressure	38.5	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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