

PENTAMID B GK15 H natural

Polyamide 6

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 6, 15% glass bead reinforced

General Information				
Filler / Reinforcement	Glass beads, 15% filler by weight			
Additive	heat stabilizer			
Features	Thermal Stability			
Agency Ratings	EC 1907/2006 (REACH)			
Appearance	Natural color			
Forms	Particle			
Processing Method	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.23	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.1	--	%	ISO 294-4
Flow	1.1	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.1	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.3	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3800	1750	MPa	ISO 527-2/1
Tensile Stress (Break)	70.0	45.0	MPa	ISO 527-2/5
Tensile Strain (Break)	11	> 25	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	90 kJ/m ²	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	75.0	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	32	--	kV/mm	IEC 60243-1

Dielectric Constant (1 MHz)	3.90	--		IEC 60250
Comparative Tracking Index	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.6 mm	HB	--		UL 94
3.2 mm	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA6, MHR, 14-040 N, GB15	--		ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.070 - 0.15		%	
Suggested Max Regrind	20		%	
Rear Temperature	260 - 280		°C	
Middle Temperature	265 - 290		°C	
Front Temperature	270 - 280		°C	
Processing (Melt) Temp	255 - 295		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	62.5		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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