

PENTAMID B S L H natural

Polyamide 6
PENTAC Polymer GmbH

Message:
Low viscosity, impact modified, heat stabilised polyamide 6

General Information				
Additive		Impact modifier heat stabilizer		
Features		Impact modification Low viscosity Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	2.1	--	%	ISO 294-4
Flow	1.7	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	9.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.6	--	%	ISO 62
Viscosity Number	130	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2600	1100	MPa	ISO 527-2/1
Tensile Stress (Yield)	71.0	45.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	4.4	13	%	ISO 527-2/50
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	25	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	170	--	°C	ISO 75-2/B

1.8 MPa, not annealed	60.0	--	°C	ISO 75-2/A
Melting Temperature	223	--	°C	ISO 11357-3
Flammability	Dry	Conditioned		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-I, MHR, 12-020	--		ISO 1874
Injection	Dry	Unit		
Drying Temperature	70		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.10 - 0.18		%	
Suggested Max Regrind	20		%	
Rear Temperature	255 - 275		°C	
Middle Temperature	260 - 285		°C	
Front Temperature	265 - 275		°C	
Processing (Melt) Temp	250 - 290		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	55.0		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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