

# PENTAMID B GV10 MA20 H RC schwarz

Polyamide 6  
PENTAC Polymer GmbH

Message:  
Normal viscosity, heat stabilised polyamide 6, 10% glass fiber and 20% mineral reinforced, Recompound

| General Information                     |      |                                                                                               |                    |             |
|-----------------------------------------|------|-----------------------------------------------------------------------------------------------|--------------------|-------------|
| Filler / Reinforcement                  |      | Glass fiber reinforced material, 10% filler by weight<br>Mineral filler, 20% filler by weight |                    |             |
| Additive                                |      | heat stabilizer                                                                               |                    |             |
| Recycled Content                        |      | Yes                                                                                           |                    |             |
| Features                                |      | Thermal Stability                                                                             |                    |             |
| Agency Ratings                          |      | EC 1907/2006 (REACH)                                                                          |                    |             |
| Appearance                              |      | Black                                                                                         |                    |             |
| Forms                                   |      | Particle                                                                                      |                    |             |
| Physical                                | Dry  | Conditioned                                                                                   | Unit               | Test Method |
| Density                                 | 1.36 | --                                                                                            | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                       |      |                                                                                               |                    | ISO 294-4   |
| Vertical flow direction                 | 0.80 | --                                                                                            | %                  | ISO 294-4   |
| Flow direction                          | 0.50 | --                                                                                            | %                  | 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                        | 130  | --                                                                                            | cm <sup>3</sup> /g | ISO 307     |
| Hardness                                | Dry  | Conditioned                                                                                   | Unit               | Test Method |
| Ball Indentation Hardness (H 961/30)    | 185  | --                                                                                            | MPa                | ISO 2039-1  |
| Mechanical                              | Dry  | Conditioned                                                                                   | Unit               | Test Method |
| Tensile Modulus                         | 6400 | 4800                                                                                          | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                  | 100  | 65.0                                                                                          | MPa                | ISO 527-2   |
| Tensile Strain (Break)                  | 4.0  | 5.0                                                                                           | %                  | ISO 527-2   |
| Impact                                  | Dry  | Conditioned                                                                                   | Unit               | Test Method |
| Charpy Notched Impact Strength (23°C)   | 3.0  | 7.0                                                                                           | kJ/m <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 40   | 60                                                                                            | kJ/m <sup>2</sup>  | ISO 179/1eU |
| Thermal                                 | Dry  | Conditioned                                                                                   | Unit               | Test Method |
| Heat Deflection Temperature             |      |                                                                                               |                    |             |
| 0.45 MPa, not annealed                  | 215  | --                                                                                            | °C                 | ISO 75-2/B  |

|                               |      |             |       |             |
|-------------------------------|------|-------------|-------|-------------|
| 1.8 MPa, not annealed         | 195  | --          | °C    | ISO 75-2/A  |
| Melting Temperature (DSC)     | 222  | --          | °C    | ISO 3146    |
| Electrical                    | Dry  | Conditioned | Unit  | Test Method |
| Dielectric Strength (1.00 mm) | 33   | --          | kV/mm | IEC 60243-1 |
| Relative Permittivity (1 MHz) | 3.50 | --          |       | IEC 60250   |
| Comparative Tracking Index    | 450  | --          | 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

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ISO Description: PA6, MHRC, 14-060, GF10+MD20The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的  
ISO Description: PA6, MHRC, 14-060, GF10+MD20

|                         |                    |      |  |
|-------------------------|--------------------|------|--|
| Injection               | Dry                | Unit |  |
| Drying Temperature      | 80.0               | °C   |  |
| Drying Time             | 3.0                | hr   |  |
| Suggested Max Moisture  | 0.090              | %    |  |
| Suggested Max Regrind   | 20                 | %    |  |
| Rear Temperature        | 260 - 280          | °C   |  |
| Middle Temperature      | 280 - 295          | °C   |  |
| Front Temperature       | 280 - 290          | °C   |  |
| Processing (Melt) Temp  | 280                | °C   |  |
| Mold Temperature        | 80.0               | °C   |  |
| Injection Pressure      | 70.0               | MPa  |  |
| Holding Pressure        | 42.0               | 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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