

PENTAMID B GV25 H natur

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 25% glass fiber reinforced

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Uses		Switches		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural Color		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.70	--	%	
Flow	0.40	--	%	
Water Absorption				ISO 62
Saturation, 23°C	7.2	--	%	
Equilibrium, 23°C, 50% RH	2.3	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	210	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8200	5600	MPa	ISO 527-2/1
Tensile Stress (Break)	160	100	MPa	ISO 527-2
Tensile Strain (Break)	4.3	8.0	%	ISO 527-2
Flexural Modulus	7100	--	MPa	ISO 178
Flexural Stress	215	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	14	15	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	80	90	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	215	--	°C	ISO 75-2/B

1.8 MPa, Unannealed	205	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Electric Strength (1.00 mm)	35	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.80	--		IEC 60250
Comparative Tracking Index	525	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	HB	--		
3.20 mm	HB	--		
Additional Information	Dry	Conditioned		Test Method
ISO Type				
--	--	PA6, MHR, 14-080, GF25		ISO 1874
--	PA6, MHR, 14-080, GF25	--		ISO 11357
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.10		%	
Suggested Max Regrind	20		%	
Rear Temperature	260 to 285		°C	
Middle Temperature	275 to 290		°C	
Front Temperature	275 to 285		°C	
Processing (Melt) Temp	280		°C	
Mold Temperature	80.0		°C	
Injection Pressure	67.5		MPa	
Holding Pressure	40.5		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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