

PENTALLOY BS 6 H natur

Acrylonitrile Butadiene Styrene + Nylon

PENTAC Polymer GmbH

Message:

PA-ABS alloy, unreinforced, heat stabilised

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
	Excellent appearance		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Natural color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.4	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	3.5	%	ISO 62
Equilibrium, 23°C, 50% RH	1.4	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	70.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1850	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2
Yield	50.0	MPa	ISO 527-2
Fracture	43.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield	3.5	%	ISO 527-2
Fracture	70	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	19	kJ/m ²	ISO 179/1eA
23°C	85	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, not annealed	110	°C	ISO 75-2/B
1.8 MPa, not annealed	80.0	°C	ISO 75-2/A
Melting Temperature (DSC)	222	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (1.00 mm)	28	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.10		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Additional Information			
The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.Tensile Strain at Break, ISO 527: >70%			
Injection	Nominal Value	Unit	
Drying Temperature	70.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.14	%	
Suggested Max Regrind	20	%	
Rear Temperature	245 - 270	°C	
Middle Temperature	260 - 275	°C	
Front Temperature	260 - 270	°C	
Processing (Melt) Temp	265	°C	
Mold Temperature	80.0	°C	
Injection Pressure	50.0	MPa	
Holding Pressure	30.0	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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