

PENTAMID B S GV25 H FR natural

Polyamide 6
PENTAC Polymer GmbH

Message:
Low viscosity, heat stabilised polyamide 6, 25% glass fiber reinforced, flame retardant

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Additive	heat stabilizer		
	Flame retardancy		
Features	Low viscosity		
	Thermal Stability		
	Flame retardancy		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.90	%	ISO 294-4
Flow	0.40	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	5.8	%	ISO 62
Equilibrium, 23°C, 50% RH	1.9	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1
Tensile Stress (Break)	130	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	215	°C	ISO 75-2/B
1.8 MPa, not annealed	210	°C	ISO 75-2/A
Melting Temperature	222	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method

Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 100	mm/min	FMVSS 302
Flame Rating (0.8 mm)	V-0		UL 94
Glow Wire Flammability Index (0.8 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (0.8 mm)	800	°C	IEC 60695-2-13
Additional Information	Nominal Value		Test Method
ISO Shortname	PA6, MFHR, 12-100, GF25 (FR)		ISO 1874
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.050 - 0.13	%	
Suggested Max Regrind	20	%	
Rear Temperature	265 - 285	°C	
Middle Temperature	270 - 295	°C	
Front Temperature	275 - 285	°C	
Processing (Melt) Temp	260 - 300	°C	
Mold Temperature	60 - 100	°C	
Injection Pressure	71.5	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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