

PENTAMID A MK30 E H natural

Polyamide 66

PENTAC Polymer GmbH

Message:

Normal viscosity, heat stabilised polyamide 66, 30% mineral filled, impact modified

General Information				
Filler / Reinforcement		Mineral filler, 30% filler by weight		
Additive		Impact modifier heat stabilizer		
Features		Impact modification Thermal Stability		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.70	--	%	ISO 294-4
Flow	0.70	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	5.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.5	--	%	ISO 62
Viscosity Number	140	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	4200	2200	MPa	ISO 527-2/1
Tensile Stress (Break)	70.0	50.0	MPa	ISO 527-2/5
Tensile Strain (Break)	12	> 25	%	ISO 527-2/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	6.0	--	kJ/m ²	ISO 179/1eA
23°C	10	13	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	90	--	kJ/m ²	ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	220	--	°C	ISO 75-2/B
1.8 MPa, not annealed	85.0	--	°C	ISO 75-2/A
Melting Temperature	260	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	35	--	kV/mm	IEC 60243-1
Comparative Tracking Index	500	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm)	HB	--		UL 94
Additional Information	Dry	Conditioned		Test Method
ISO Shortname	PA66-HI, MHR, 14-040 N, MD30-			ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.040 - 0.12		%	
Suggested Max Regrind	20		%	
Rear Temperature	270 - 290		°C	
Middle Temperature	275 - 300		°C	
Front Temperature	280 - 290		°C	
Processing (Melt) Temp	270 - 300		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	75.0		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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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