

# PENTAMID A GV30 L8 H schwarz

Polyamide 66

PENTAC Polymer GmbH

## Message:

Normal viscosity, heat stabilised polyamide 66, 30% glass fiber reinforced, impact modified

| General Information                     |      |                                                       |                    |             |
|-----------------------------------------|------|-------------------------------------------------------|--------------------|-------------|
| Filler / Reinforcement                  |      | Glass fiber reinforced material, 30% filler by weight |                    |             |
| Additive                                |      | Impact modifier<br>heat stabilizer                    |                    |             |
| Features                                |      | Impact modification<br>Thermal Stability              |                    |             |
| Uses                                    |      | Shell                                                 |                    |             |
| Agency Ratings                          |      | EC 1907/2006 (REACH)                                  |                    |             |
| Appearance                              |      | Black                                                 |                    |             |
| Forms                                   |      | Particle                                              |                    |             |
| Physical                                | Dry  | Conditioned                                           | Unit               | Test Method |
| Density                                 | 1.32 | --                                                    | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                       |      |                                                       |                    | ISO 294-4   |
| Vertical flow direction                 | 0.65 | --                                                    | %                  | ISO 294-4   |
| Flow direction                          | 0.40 | --                                                    | %                  | ISO 294-4   |
| Water Absorption                        |      |                                                       |                    | ISO 62      |
| Saturated, 23°C                         | 4.9  | --                                                    | %                  | ISO 62      |
| Equilibrium, 23°C, 50% RH               | 1.4  | --                                                    | %                  | ISO 62      |
| Viscosity Number                        | 140  | --                                                    | cm <sup>3</sup> /g | ISO 307     |
| Hardness                                | Dry  | Conditioned                                           | Unit               | Test Method |
| Ball Indentation Hardness (H 961/30)    | 200  | --                                                    | MPa                | ISO 2039-1  |
| Mechanical                              | Dry  | Conditioned                                           | Unit               | Test Method |
| Tensile Modulus                         | 8600 | 5600                                                  | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                  | 140  | 110                                                   | MPa                | ISO 527-2   |
| Tensile Strain (Break)                  | 3.5  | 6.0                                                   | %                  | ISO 527-2   |
| Impact                                  | Dry  | Conditioned                                           | Unit               | Test Method |
| Charpy Notched Impact Strength (23°C)   | 20   | 25                                                    | kJ/m <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 70   | 85                                                    | kJ/m <sup>2</sup>  | ISO 179/1eU |
| Thermal                                 | Dry  | Conditioned                                           | Unit               | Test Method |

|                               |      |             |       |             |
|-------------------------------|------|-------------|-------|-------------|
| Heat Deflection Temperature   |      |             |       |             |
| 0.45 MPa, not annealed        | 235  | --          | °C    | ISO 75-2/B  |
| 1.8 MPa, not annealed         | 190  | --          | °C    | ISO 75-2/A  |
| Melting Temperature (DSC)     | 260  | --          | °C    | ISO 3146    |
| Electrical                    | Dry  | Conditioned | Unit  | Test Method |
| Dielectric Strength (1.00 mm) | 34   | --          | kV/mm | IEC 60243-1 |
| Relative Permittivity (1 MHz) | 3.50 | --          |       | IEC 60250   |
| Comparative Tracking Index    | 550  | --          | 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: PA66-HI, MHRC, 14-090 N, GF30The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA66-HI, MHRC, 14-090 N, GF30

|                         |                    |      |
|-------------------------|--------------------|------|
| Injection               | Dry                | Unit |
| Drying Temperature      | 75.0               | °C   |
| Drying Time             | 3.0                | hr   |
| Suggested Max Moisture  | 0.090              | %    |
| Suggested Max Regrind   | 20                 | %    |
| Rear Temperature        | 260 - 285          | °C   |
| Middle Temperature      | 275 - 290          | °C   |
| Front Temperature       | 275 - 285          | °C   |
| Processing (Melt) Temp  | 280                | °C   |
| Mold Temperature        | 80.0               | °C   |
| Injection Pressure      | 78.0               | MPa  |
| Holding Pressure        | 46.8               | 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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