

PENTAMID B GV15 E H schwarz

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity, heat stabilised polyamide 6, 15% glass fiber reinforced, impact modified

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Additive		Impact modifier heat stabilizer		
Features		Impact modification Rigid, good Impact resistance, good Thermal Stability		
Uses		Sporting goods		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.21	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.85	--	%	ISO 294-4
Flow direction	0.60	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.4	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	170	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5250	2700	MPa	ISO 527-2/1
Tensile Stress (Break)	110	65.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	12	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	7.0	--	kJ/m ²	ISO 179/1eA

23°C	17	22	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	70	85	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	195	--	°C	ISO 75-2/B
1.8 MPa, not annealed	180	--	°C	ISO 75-2/A
Melting Temperature (DSC)	222	--	°C	ISO 3146
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength (1.00 mm)	32	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.40	--		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: PA6-HI, MHRC, 14-050 N, GF15The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

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ISO Description: PA6-HI, MHRC, 14-050 N, GF15

Injection	Dry	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.11	%	
Suggested Max Regrind	20	%	
Rear Temperature	255 - 280	°C	
Middle Temperature	270 - 285	°C	
Front Temperature	270 - 280	°C	
Processing (Melt) Temp	275	°C	
Mold Temperature	80.0	°C	
Injection Pressure	65.0	MPa	
Holding Pressure	39.0	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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