# PENTAMID B SK H natur

Polyamide 6

PENTAC Polymer GmbH

## Message:

normal viscosity, heat stabilised polyamide 6 for short cycle times

| General Information | | | | |
|---|---|---|---|---|
| Additive | heat stabilizer | | | |
| Features | Fast molding cycle<br>Thermal Stability | | | |
| Uses | Switch<br>Shell | | | |
| Agency Ratings | EC 1907/2006 (REACH) | | | |
| Appearance | Natural color | | | |
| Forms | Particle | | | |
| **Physical** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Density | 1.13 | -- | g/cm³ | ISO 1183 |
| Molding Shrinkage | | | | ISO 294-4 |
| Vertical flow direction | 1.6 | -- | % | ISO 294-4 |
| Flow direction | 1.6 | -- | % | ISO 294-4 |
| Water Absorption | | | | ISO 62 |
| Saturated, 23°C | 9.0 | -- | % | ISO 62 |
| Equilibrium, 23°C, 50% RH | 3.4 | -- | % | ISO 62 |
| Viscosity Number | 145 | -- | cm³/g | ISO 307 |
| **Hardness** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Ball Indentation Hardness (H 358/30) | 165 | -- | MPa | ISO 2039-1 |
| **Mechanical** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Tensile Modulus | 3200 | 1100 | MPa | ISO 527-2/1 |
| Tensile Stress (Yield) | 85.0 | 50.0 | MPa | ISO 527-2 |
| Tensile Strain (Yield) | 4.0 | 15 | % | ISO 527-2 |
| Flexural Modulus | 3100 | -- | MPa | ISO 178 |
| Flexural Stress | 115 | -- | MPa | ISO 178 |
| **Impact** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength | | | | ISO 179/1eA |
| -30°C | 7.0 | -- | kJ/m² | ISO 179/1eA |
| 23°C | 8.0 | 22 | kJ/m² | ISO 179/1eA |

| | | | | |
|---|---|---|---|---|
| Charpy Unnotched Impact Strength | | | | ISO 179/1eU |
| -30°C | No Break | -- | | 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 | 170 | -- | °C | ISO 75-2/B |
| 1.8 MPa, not annealed | 65.0 | -- | °C | ISO 75-2/A |
| Melting Temperature (DSC) | 222 | -- | °C | ISO 3146 |
| **Electrical** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Dielectric Strength (1.00 mm) | 30 | -- | kV/mm | IEC 60243-1 |
| Relative Permittivity (1 MHz) | 3.30 | -- | | IEC 60250 |
| Comparative Tracking Index | 600 | -- | V | IEC 60112 |
| **Flammability** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Flame Rating | | | | UL 94 |
| 1.60 mm | V-2 | -- | | UL 94 |
| 3.20 mm | V-2 | -- | | UL 94 |

**Additional Information**

干燥
ISO Description: PA6, MHR, 14-030 NThe value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的
ISO Description: PA6, MHR, 14-030 N

| Injection | Dry | Unit |
|---|---|---|
| Drying Temperature | 80.0 | °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 | 55.0 | MPa |
| Holding Pressure | 33.0 | MPa |
| Screw L/D Ratio | 20.0:1.0 | |
| Screw Compression Ratio | 2.2:1.0 to 2.8:1.0 | |

Recommended distributors for this material

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