

# PENTAMID A GV25 H green 6011/1

Polyamide 66

PENTAC Polymer GmbH

## Message:

Normal viscosity, heat stabilised polyamide 66, 25% glass fiber reinforced, Special Pigmentation

| General Information                     |                                                       |             |                    |             |
|-----------------------------------------|-------------------------------------------------------|-------------|--------------------|-------------|
| Filler / Reinforcement                  | Glass fiber reinforced material, 25% filler by weight |             |                    |             |
| Additive                                | heat stabilizer                                       |             |                    |             |
| Features                                | Thermal Stability                                     |             |                    |             |
| Agency Ratings                          | EC 1907/2006 (REACH)                                  |             |                    |             |
| Appearance                              | Green                                                 |             |                    |             |
| Forms                                   | Particle                                              |             |                    |             |
| Processing Method                       | Injection molding                                     |             |                    |             |
| Physical                                | Dry                                                   | Conditioned | Unit               | Test Method |
| Density                                 | 1.32                                                  | --          | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                       |                                                       |             |                    | ISO 294-4   |
| Transverse flow                         | 0.90                                                  | --          | %                  | ISO 294-4   |
| Flow                                    | 0.60                                                  | --          | %                  | ISO 294-4   |
| Water Absorption                        |                                                       |             |                    | ISO 62      |
| Saturated, 23°C                         | 6.2                                                   | --          | %                  | ISO 62      |
| Equilibrium, 23°C, 50% RH               | 1.9                                                   | --          | %                  | ISO 62      |
| Viscosity Number                        | 140                                                   | --          | cm <sup>3</sup> /g | ISO 307     |
| Mechanical                              | Dry                                                   | Conditioned | Unit               | Test Method |
| Tensile Modulus                         | 7600                                                  | 5400        | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                  | 145                                                   | 100         | MPa                | ISO 527-2/5 |
| Tensile Strain (Break)                  | 3.5                                                   | 6.0         | %                  | ISO 527-2/5 |
| Flexural Modulus                        | 7100                                                  | --          | MPa                | ISO 178     |
| Flexural Stress                         | 200                                                   | --          | MPa                | ISO 178     |
| Impact                                  | Dry                                                   | Conditioned | Unit               | Test Method |
| Charpy Notched Impact Strength (23°C)   | 8.0                                                   | 9.0         | kJ/m <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 45                                                    | 60          | kJ/m <sup>2</sup>  | ISO 179/1eU |
| Thermal                                 | Dry                                                   | Conditioned | Unit               | Test Method |
| Heat Deflection Temperature             |                                                       |             |                    |             |
| 0.45 MPa, not annealed                  | 245                                                   | --          | °C                 | ISO 75-2/B  |
| 1.8 MPa, not annealed                   | 220                                                   | --          | °C                 | ISO 75-2/A  |
| Melting Temperature                     | 260                                                   | --          | °C                 | ISO 11357-3 |

| Electrical                  | Dry                        | Conditioned | Unit  | Test Method |
|-----------------------------|----------------------------|-------------|-------|-------------|
| Dielectric Strength         | 33                         | --          | kV/mm | IEC 60243-1 |
| Dielectric Constant (1 MHz) | 3.50                       | --          |       | IEC 60250   |
| Comparative Tracking Index  | 450                        | --          | 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, MHRC, 14-080 N, GF25 | --          |       | ISO 1874    |
| Injection                   | Dry                        | Unit        |       |             |
| Drying Temperature          | 80                         |             | °C    |             |
| Drying Time                 | 3.0                        |             | hr    |             |
| Suggested Max Moisture      | 0.060 - 0.14               |             | %     |             |
| Suggested Max Regrind       | 20                         |             | %     |             |
| Rear Temperature            | 265 - 285                  |             | °C    |             |
| Middle Temperature          | 270 - 290                  |             | °C    |             |
| Front Temperature           | 275 - 285                  |             | °C    |             |
| Processing (Melt) Temp      | 265 - 295                  |             | °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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