

PENTAMID B SK H schwarz

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		
		Thermal Stability		
Uses		Switch		
		Shell		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Black		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	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	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	155	--	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	6.0	--	kJ/m ²	ISO 179/1eA
23°C	8.0	22	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	80	--	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	175	--	°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
3.20 mm	HB	--		UL 94
1.60 mm	V-2	--		UL 94
Additional Information				

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

调节后的
ISO Description: PA6, MHRC, 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	

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