

# PENTAMID A GV35 H black

Polyamide 66  
PENTAC Polymer GmbH

Message:  
Normal viscosity, heat stabilised polyamide 66, 35% glass fiber reinforced

| General Information                     |                          |                                                       |                    |             |
|-----------------------------------------|--------------------------|-------------------------------------------------------|--------------------|-------------|
| Filler / Reinforcement                  |                          | Glass fiber reinforced material, 35% filler by weight |                    |             |
| Additive                                |                          | heat stabilizer                                       |                    |             |
| Features                                |                          | Thermal Stability                                     |                    |             |
| Agency Ratings                          |                          | EC 1907/2006 (REACH)                                  |                    |             |
| Appearance                              |                          | Black                                                 |                    |             |
| Forms                                   |                          | Particle                                              |                    |             |
| Processing Method                       |                          | Injection molding                                     |                    |             |
| Physical                                | Dry                      | Conditioned                                           | Unit               | Test Method |
| Density                                 | 1.41                     | --                                                    | g/cm <sup>3</sup>  | ISO 1183    |
| Viscosity Number                        | 140                      | --                                                    | cm <sup>3</sup> /g | ISO 307     |
| Mechanical                              | Dry                      | Conditioned                                           | Unit               | Test Method |
| Tensile Modulus                         | 11000                    | 8500                                                  | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                  | 200                      | 140                                                   | MPa                | ISO 527-2/5 |
| Tensile Strain (Break)                  | 3.0                      | 4.2                                                   | %                  | ISO 527-2/5 |
| Impact                                  | Dry                      | Conditioned                                           | Unit               | Test Method |
| Charpy Notched Impact Strength (23°C)   | 14                       | 17                                                    | kJ/m <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 90                       | 90                                                    | kJ/m <sup>2</sup>  | ISO 179/1eU |
| Thermal                                 | Dry                      | Conditioned                                           | Unit               | Test Method |
| Heat Deflection Temperature             |                          |                                                       |                    |             |
| 0.45 MPa, not annealed                  | 255                      | --                                                    | °C                 | ISO 75-2/B  |
| 1.8 MPa, not annealed                   | 250                      | --                                                    | °C                 | ISO 75-2/A  |
| Melting Temperature                     | 260                      | --                                                    | °C                 | ISO 11357-3 |
| Electrical                              | Dry                      | Conditioned                                           | Unit               | Test Method |
| Dielectric Strength                     | 60                       | --                                                    | 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, 14-110, GF35 | --                                                    |                    | ISO 1874    |

| Injection               | Dry                  | Unit |
|-------------------------|----------------------|------|
| Drying Temperature      | 80                   | °C   |
| Drying Time             | 3.0                  | hr   |
| Suggested Max Moisture  | 0.050 - 0.13         | %    |
| Suggested Max Regrind   | 20                   | %    |
| Rear Temperature        | 275 - 295            | °C   |
| Middle Temperature      | 280 - 305            | °C   |
| Front Temperature       | 285 - 295            | °C   |
| Processing (Melt) Temp  | 275 - 305            | °C   |
| Mold Temperature        | 60 - 100             | °C   |
| Injection Pressure      | 81.0                 | 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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