PENTAMID B MK30 H

PA6-MX30 — Pentac Polymer GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.8 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.9 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**5500 / 2200**	MPa	ISO 527
Stress at break	**70 / 50**	MPa	ISO 527
Strain at break	**4.8 / 13**	%	ISO 527
Charpy impact strength, +23°C	**90 / 100**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**9 / 14**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**222 / ***	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**95 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**195 / ***	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB / ***	class	IEC 60695-11-10
Thickness tested	**1.6 / ***	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	**6.7 / ***	%	Sim. to ISO 62
Humidity absorption	**2.1 / ***	%	Sim. to ISO 62
Density	**1360 / -**	kg/m³	ISO 1183

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	**145 / ***	cm³/g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**3**	h	-
Processing humidity	**≤0.13**	%	-
Melt temperature	**270**	°C	-
Mold temperature	**90**	°C	-
Feed temperature	**80**	°C	-
Zone 1	**260**	°C	-
Zone 2	**270**	°C	-
Zone 3	**275**	°C	-
Zone 4	**280**	°C	-
Zone 5	**275**	°C	-
Injection pressure	**65**	MPa	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets

Special Characteristics
Heat stabilized or stable to heat

Certifications
RoHS compliant

Applications
Encapsulation

Regional Availability
Europe