

PENTAMID B GV30 H

PA6-GF30

Pentac Polymer GmbH

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard |
|--|-------------------|-------------|----------------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.3 / * | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.5 / * | % | ISO 294-4, 2577 |

| Mechanical properties | dry / cond | Unit | Test Standard |
|---------------------------------------|-------------------|-------------------|----------------------|
| ISO Data | | | |
| Tensile Modulus | 10000 / 5500 | MPa | ISO 527 |
| Stress at break | 190 / 105 | MPa | ISO 527 |
| Strain at break | 3.5 / 6.5 | % | ISO 527 |
| Flexural modulus, 23°C | 8600 / - | MPa | ISO 178 |
| Flexural strength | 250 / - | MPa | ISO 178 |
| Charpy impact strength, +23°C | 95 / 100 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 16 / 21 | kJ/m ² | 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 | 210 / * | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 220 / * | °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/m ³ | ISO 1183 |

| Material specific properties | dry / cond | Unit | Test Standard |
|-------------------------------------|-------------------|--------------------|----------------------|
| ISO Data | | | |
| Viscosity number | 145 / * | cm ³ /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 | % | - |
| Mold temperature | 60 - 100 | °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 | - |

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

Heat stabilized or stable to heat

Certifications

RoHS compliant

Regional Availability

Europe