PENTAMID B S GV50 H

PA6-GF50 — Pentac Polymer GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**22 / ***	cm³/10min	ISO 1133
Temperature	**275 / ***	°C	-
Load	**5 / ***	kg	-
Molding shrinkage, parallel	**0.2 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.4 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**15400 / 11000**	MPa	ISO 527
Stress at break	**215 / 150**	MPa	ISO 527
Strain at break	**2.8 / 3.8**	%	ISO 527
Charpy impact strength, +23°C	**90 / 100**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**18 / 26**	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	**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	**4.8 / ***	%	Sim. to ISO 62
Humidity absorption	**1.5 / ***	%	Sim. to ISO 62
Density	**1560 / -**	kg/m³	ISO 1183

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	**120 / ***	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**	%	-
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

Certifications
RoHS compliant

Delivery form
Pellets

Regional Availability
Europe

Special Characteristics
Heat stabilized or stable to heat