

PENTAMID B H TF25 natural

Polyamide 6
PENTAC Polymer GmbH

Message:
Normal viscosity polyamide 6, modified with 25% PTFE

General Information				
Additive		PTFE lubricant (25%) heat stabilizer		
Features		Thermal Stability Lubrication		
Agency Ratings		EC 1907/2006 (REACH)		
Appearance		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.29	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.5	--	%	ISO 294-4
Flow	1.4	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	6.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	--	%	ISO 62
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2850	1000	MPa	ISO 527-2/1
Tensile Stress (Yield)	55.0	40.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.0	10	%	ISO 527-2/50
Flexural Modulus	2600	--	MPa	ISO 178
Flexural Stress	90.0	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	65	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	185	--	°C	ISO 75-2/B
1.8 MPa, not annealed	85.0	--	°C	ISO 75-2/A
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	32	--	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.30	--		IEC 60250
Comparative Tracking Index	600	--	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	PA6, MHRS, 14-030 N , X25	--		ISO 1874
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0		hr	
Suggested Max Moisture	0.10 - 0.18		%	
Suggested Max Regrind	20		%	
Rear Temperature	265 - 285		°C	
Middle Temperature	270 - 295		°C	
Front Temperature	275 - 285		°C	
Processing (Melt) Temp	260 - 300		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	55.0		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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