

**PENTAMID B H TF25**

(PA6+PTFE)

Pentac Polymer GmbH

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	1.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.5 / *	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	2850 / 1000	MPa	ISO 527
Yield stress	55 / 40	MPa	ISO 527
Yield strain	3 / 10	%	ISO 527
Flexural modulus, 23°C	2600 / -	MPa	ISO 178
Flexural strength	90 / -	MPa	ISO 178
Charpy impact strength, +23°C	50 / 65	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	3.5 / 8	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	85 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	185 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Water absorption	6.8 / *	%	Sim. to ISO 62
Humidity absorption	2.5 / *	%	Sim. to ISO 62
Density	1290 / -	kg/m <sup>3</sup>	ISO 1183

<b>Film Properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Dynamic coefficient of friction	0.21 / *	-	ISO 8295

<b>Material specific properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Viscosity number	145 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**Special Characteristics**

Heat stabilized or stable to heat

**Delivery form**

Pellets

**Certifications**

RoHS compliant

**PENTAMID B H TF25**

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**Additives**

Lubricants

**Regional Availability**

Europe