

PENTAMID A H TF20

(PA66+PTFE)

Pentac Polymer GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.6 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	2900 / 1100	MPa	ISO 527
Yield stress	70 / 45	MPa	ISO 527
Yield strain	3.2 / 12	%	ISO 527
Flexural modulus, 23°C	2800 / -	MPa	ISO 178
Flexural strength	95 / -	MPa	ISO 178
Charpy impact strength, +23°C	65 / 80	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	5 / 10	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	260 / *	°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	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	6.9 / *	%	Sim. to ISO 62
Humidity absorption	2.4 / *	%	Sim. to ISO 62
Density	1250 / -	kg/m ³	ISO 1183

Film Properties	dry / cond	Unit	Test Standard
ISO Data			
Dynamic coefficient of friction	0.18 / *	-	ISO 8295

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	140 / *	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	270	°C	-
Zone 2	280	°C	-
Zone 3	285	°C	-
Zone 4	290	°C	-
Zone 5	285	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Pellets

Certifications

RoHS compliant

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Additives

Lubricants

Regional Availability

Europe