

PENTAMID B H TF25 black

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	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	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	Nominal Value	Unit	Test Method
Tensile Modulus	2850	MPa	ISO 527-2/1
Tensile Stress (Yield)	55.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.0	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	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
Flammability	Nominal Value		Test Method
Flame Rating (3.2 mm)	HB		UL 94

Additional Information	Nominal Value	Test Method
ISO Shortname	PA6, MHRCS, 14-030 N, X25	ISO 1874
Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.10 - 0.18	%
Suggested Max Regrind	20	%
Rear Temperature	260 - 280	°C
Middle Temperature	265 - 290	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	255 - 295	°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

