

# PENTAMID B H TF25 gelb

Polyamide 6  
PENTAC Polymer GmbH

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

| General Information                     |                      |             |                    |             |
|-----------------------------------------|----------------------|-------------|--------------------|-------------|
| Additive                                | PTFE lubricant (25%) |             |                    |             |
| Uses                                    | Bearing              |             |                    |             |
| Agency Ratings                          | EC 1907/2006 (REACH) |             |                    |             |
| Appearance                              | Yellow               |             |                    |             |
| Forms                                   | Particle             |             |                    |             |
| Physical                                | Dry                  | Conditioned | Unit               | Test Method |
| Density                                 | 1.29                 | --          | g/cm <sup>3</sup>  | ISO 1183    |
| Molding Shrinkage                       |                      |             |                    | ISO 294-4   |
| Vertical flow direction                 | 1.5                  | --          | %                  | ISO 294-4   |
| Flow direction                          | 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 <sup>3</sup> /g | ISO 307     |
| Hardness                                | Dry                  | Conditioned | Unit               | Test Method |
| Ball Indentation Hardness (H 358/30)    | 160                  | --          | MPa                | ISO 2039-1  |
| 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   |
| Tensile Strain (Yield)                  | 3.0                  | 10          | %                  | ISO 527-2   |
| 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 <sup>2</sup>  | ISO 179/1eA |
| Charpy Unnotched Impact Strength (23°C) | 50                   | 65          | kJ/m <sup>2</sup>  | 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 (DSC)               | 222                  | --          | °C                 | ISO 3146    |

| Electrical                    | Dry  | Conditioned | Unit  | Test Method |
|-------------------------------|------|-------------|-------|-------------|
| Dielectric Strength (1.00 mm) | 32   | --          | kV/mm | IEC 60243-1 |
| Relative Permittivity (1 MHz) | 3.30 | --          |       | IEC 60250   |
| Comparative Tracking Index    | 600  | --          | V     | IEC 60112   |
| Flammability                  | Dry  | Conditioned | Unit  | Test Method |
| Flame Rating (3.20 mm)        | HB   | --          |       | UL 94       |
| Additional Information        |      |             |       |             |

干燥  
ISO Description: PA6, MHRCS, 14-030 N, X25The value listed as Melting Point, ISO 3146, was tested in accordance with ISO 11357.

调节后的  
ISO Description: PA6, MHRCS, 14-030 N, X25

| Injection               | Dry                | Unit |
|-------------------------|--------------------|------|
| Drying Temperature      | 80.0               | °C   |
| Drying Time             | 3.0                | hr   |
| Suggested Max Moisture  | 0.14               | %    |
| Suggested Max Regrind   | 20                 | %    |
| Rear Temperature        | 255 - 280          | °C   |
| Middle Temperature      | 270 - 285          | °C   |
| Front Temperature       | 270 - 280          | °C   |
| Processing (Melt) Temp  | 275                | °C   |
| Mold Temperature        | 80.0               | °C   |
| Injection Pressure      | 55.0               | MPa  |
| Holding Pressure        | 33.0               | MPa  |
| Screw L/D Ratio         | 20.0:1.0           |      |
| Screw Compression Ratio | 2.2:1.0 to 2.8:1.0 |      |

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