Technical information

TEREZ® PA 6 7100 X

Medium viscosity standard quality with good flow characteristics.

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TECHNICAL DATA SHEET

Product text

For long and short cycle times.

Properties	Value	Unit	Test method
Density	1,1300	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	7,5	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	NB	kJ/m²	ISO 179
Elongation at yield, dry	3,30	%	ISO 527
Tensile stress at yield, dry	92	MPa	ISO 527
Tensile-modulus, dry	3700	MPa	ISO 527
Elongation at break, dry	14,00	%	ISO 527
HDT 0,45 MPa	185	°C	ISO 75
HDT 1,80 MPa	65	°C	ISO 75
Burning Behav. at thickness h	V-2	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	8,90	%	ISO 62
Moisture absorption	2,60	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PA 6 7100 X

The processing data sheet provides guidelines about processing as well as pre-drying.

MATERIAL PREPARATION

Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

Dry air dryer

Temperature	80°C
Time	4 - 8 hours
Due point	-40°C

Residual moisture

<= 0.05% (recommended)
max. 0.1% (standard)

MACHINE REQUIREMENTS

PROCESSING

Basic settings

The following basic settings are generally to be selected:

Processing temperatures

Hopper	60 - 80°C
Center	240 - 260°C
Nozzle	250 - 270°C

Mold temperature

Temp.	40 - 80°C

Temperatures

Residence time

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Residence times in the cylinder

max. 265 °C / 10 min.

Instructions for cleaning

The aggregate can be cleaned by using low MFI polypropylene. You can also use standard cleaning granulate.