Technical information

preliminary

TEREZ® HT 100 H G40

Standard type with medium viscosity partly aromatic
Polyamid with 40% glass fiber content and heat stabilized

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TECHNICAL DATA SHEET

Product text

For all kind of injection mloding parts with high stiffness at exellence thermal stability and low moisture absorption

Preliminary data

Properties	Value	Unit	Test method
Density	1,5300	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	8	kJ/m²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	8	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	70	kJ/m²	ISO 179
Impact strength Charpy (23°), conditioned	70	kJ/m²	ISO 179
Tensile-modulus, dry	14500	MPa	ISO 527
Tensile-modulus, conditioned	14000	MPa	ISO 527
Tensile stress at break, dry	220	MPa	ISO 527
Tensile stress at break, conditioned	210	MPa	ISO 527
Elongation at break, dry	2,00	%	ISO 527
Elongation at break, conditioned	2,00	%	ISO 527
HDT 0,45 MPa	290	°C	ISO 75
HDT 1,80 MPa	280	°C	ISO 75
Melting point	330	°C	ISO 11357-3
CTI	550	V	IEC 60112
Electric strength	30,00	kV/mm	IEC 60243-1
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	3,30	%	ISO 62
Moisture absorption	1,50	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ HT 100 H G40

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 - 12 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:

Temperatures

Processing temperatures

Hopper	60 - 80°C
Center	330 - 340°C
Nozzle	335 - 350°C

Mold temperature

Temp.	140 - 160°C

Residence time

Residence times in the cylinder

max. 330 °C / 8 min.

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

Instructions for cleaning

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