

# Technical information

## TEREZ<sup>®</sup> PA 6 6500 A

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Medium viscosity PA6



## TECHNICAL DATA SHEET

### Product text

For all kind of application

Properties	Value	Unit	Test method
Density	1,1400	g/cm <sup>3</sup>	ISO 1183
Viscosity number (sulphuric acid)	150,00	ml/g	ISO 307
Impact strength Charpy (Notched 23°C), dry	5	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy 23°C, dry	NB	kJ/m <sup>2</sup>	ISO 179
Elongation at tear, dry	50	%	ISO 527
Tensile stress at yield, dry	80	MPa	ISO 527
Tensile-modulus, dry	2700	MPa	ISO 527
Tensile strength, dry	70	MPa	ISO 527
HDT 0,45 MPa	185	°C	ISO 75
HDT 1,80 MPa	60	°C	ISO 75
Vicat B/50	195	°C	ISO 306
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	9,50	%	ISO 62
Moisture absorption	3,00	%	ISO 62

## PROCESSING DATA SHEET

### Processing guidelines for injection molding of TEREZ PA 6 6500 A

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
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#### 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.