

Technical information

TEREZ[®] PA 6 7100

Unfilled Polyamide 6 standard quality, low-viscosity and good flowability.



TECHNICAL DATA SHEET

Product text

Good for high flow path and short cycle times.

Properties	Value	Unit	Test method
Density	1,1300	g/cm ³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	8	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	NB	kJ/m ²	ISO 179
Elongation at tear, dry	20	%	ISO 527
Elongation at yield, dry	4,00	%	ISO 527
Yield strength, dry	85	MPa	ISO 527
Tensile-modulus, dry	3200	MPa	ISO 527
Dielectric constant 1 MHz, dry	3	-	IEC 60250
Dielectric constant 100 Hz, dry	3	-	IEC 60250
Tensile strength, dry	80	MPa	ISO 527
HDT 0,45 MPa	175	°C	ISO 75
HDT 1,80 MPa	65	°C	ISO 75
CTI	550	V	IEC 60112
Surface resistivity, dry	1E+15	Ohm	IEC 60093
Volume resistivity, dry	1E+15	Ohm * m	IEC 60093
Burning Behav. at thickness h	V-2	class	UL 94
Thickness tested	1,5	mm	UL 94
UL recognition	-		UL 94
Water absorption	10,00	%	ISO 62
Moisture absorption	2,80	%	ISO 62

TER Plastics
POLYMER GROUP



PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PA 6 7100

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.